

FIG. 1

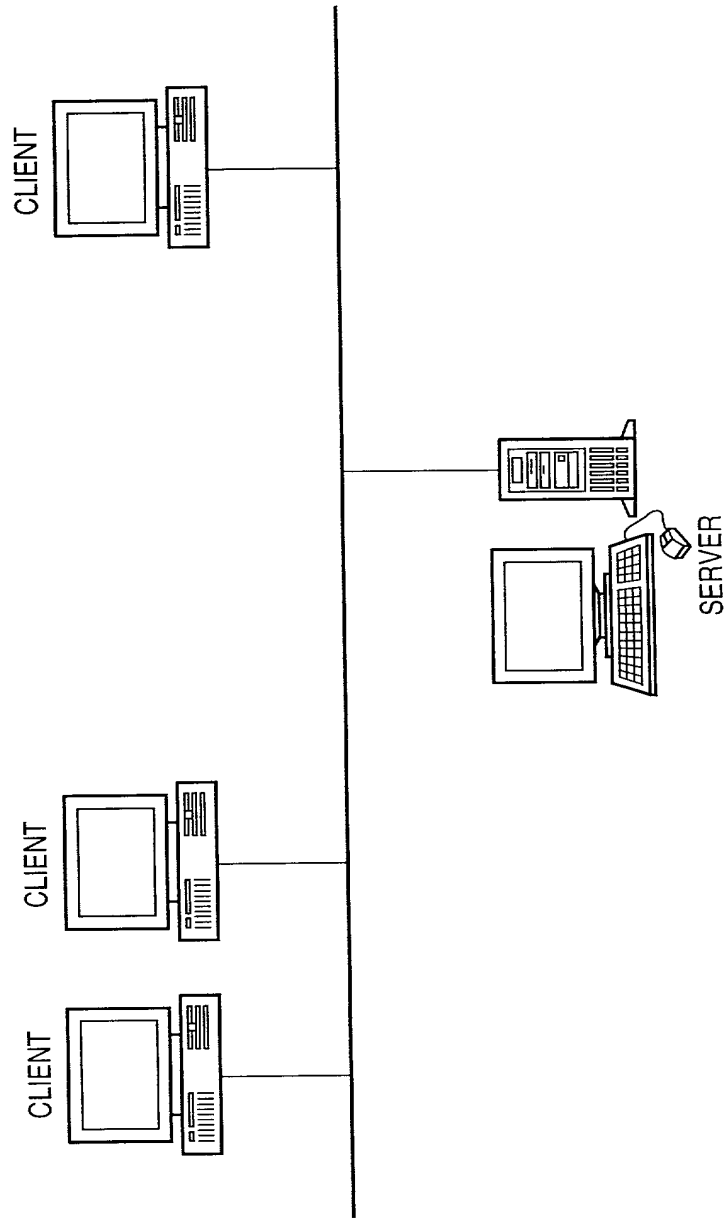


FIG. 2

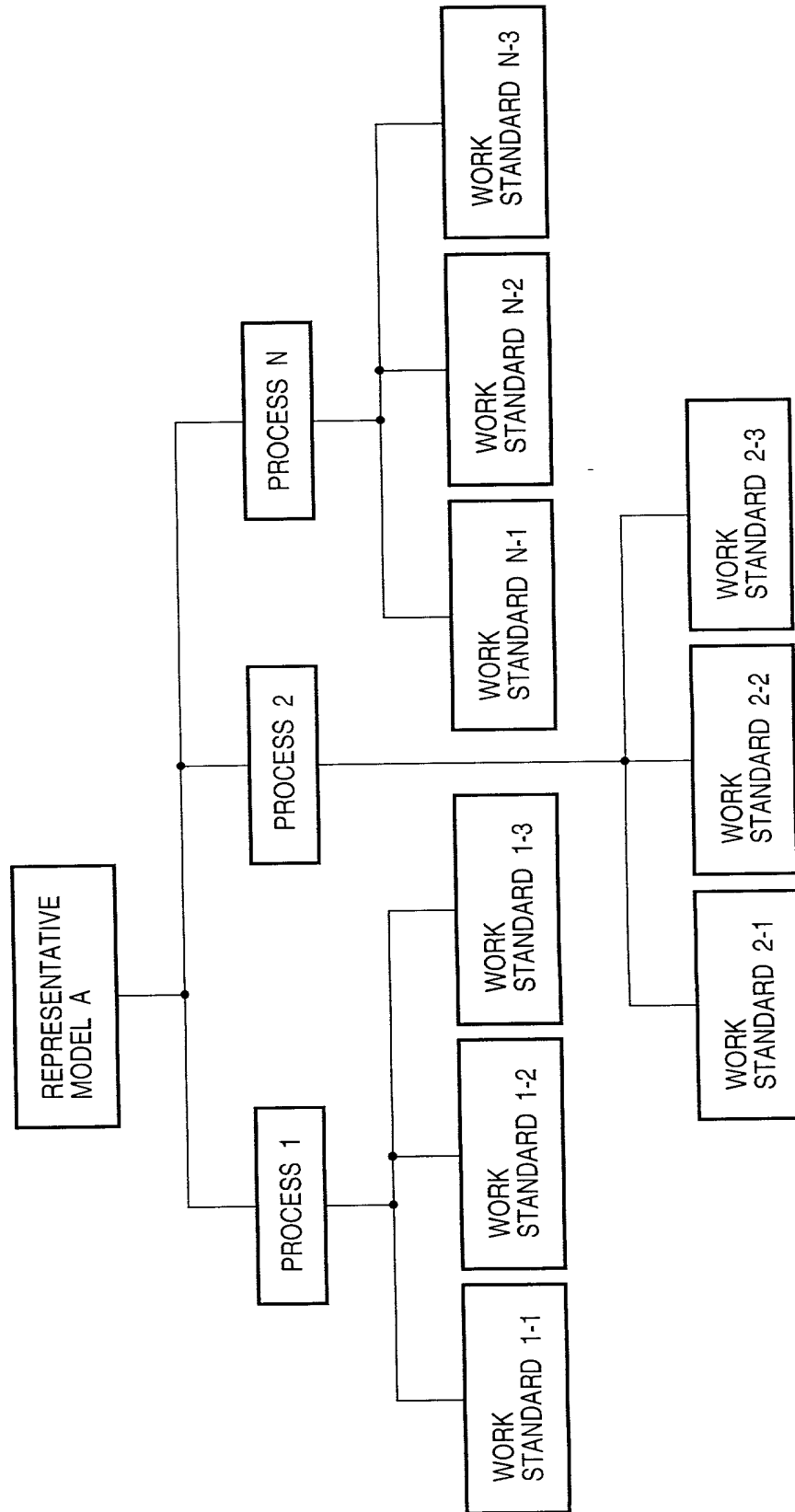


FIG. 4

STRUCTURE OF MASTER FILE

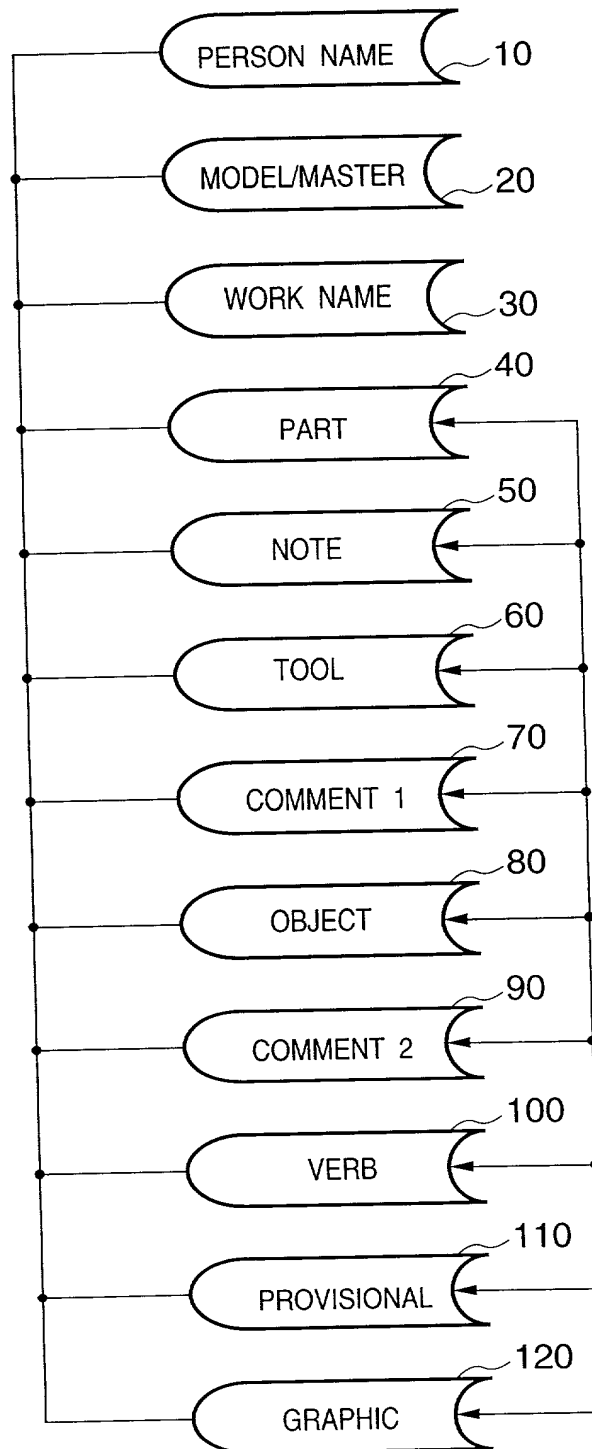


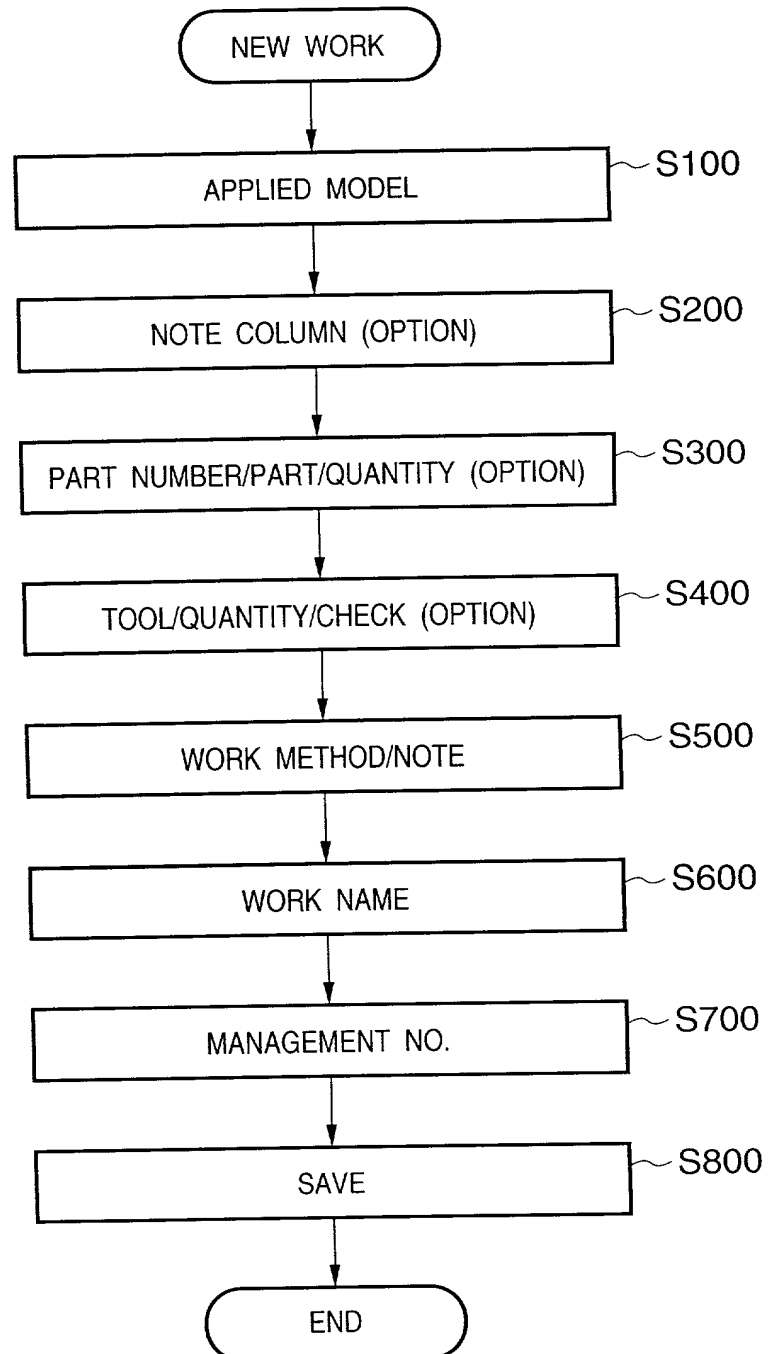
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

FIG. 7

WORK STANDARD 01 CREATION					<input type="button" value="-"/>	<input type="button" value="X"/>
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J				
PART NUMBER		PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

FIG. 8

FIG. 9

• WORK NAME

GE ____

• CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

09753941 010201

• WORK NAME

現像(GENZOU) ____

• CANDIDATES

- 現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)
- 現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))
- 現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)
- 現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)
- 現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

(COMMENT 1)

(OBJECT) ~を

(COMMENT 2)

(VERB) ~する

00 ※

01

1105a

1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK CANCEL

1108

11/97

FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

FIG. 13

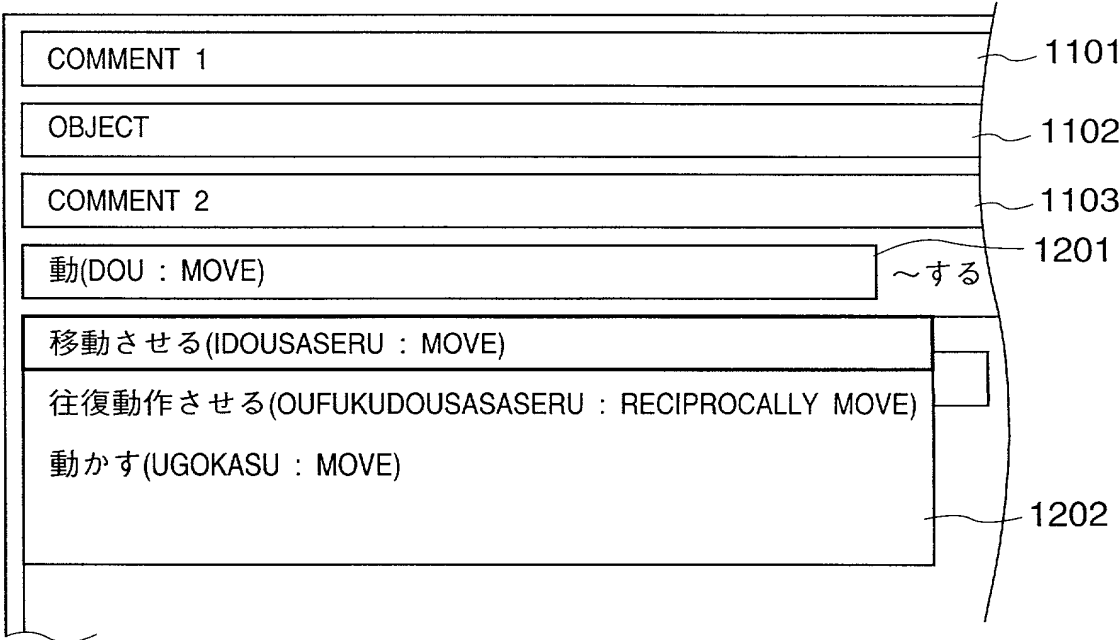


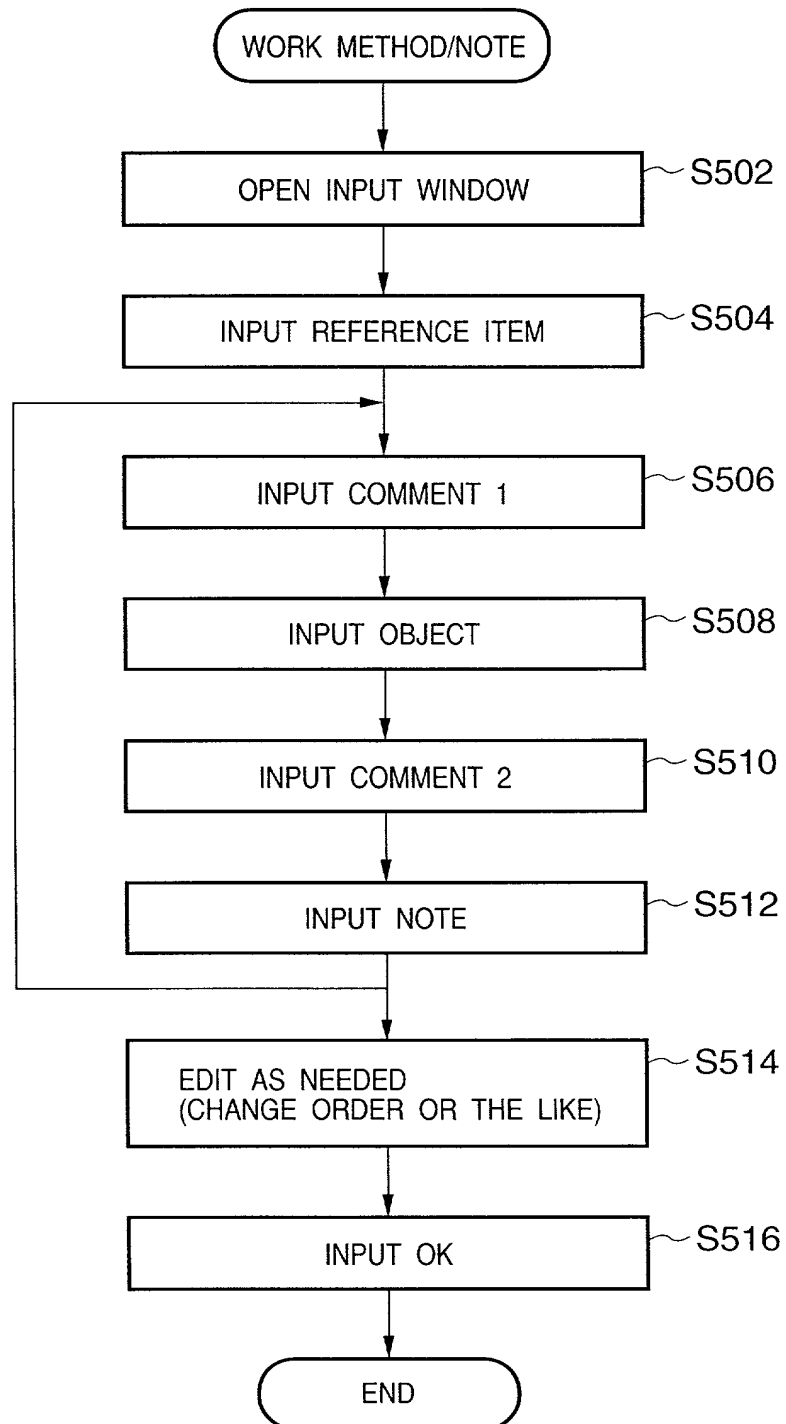
FIG. 14

FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT www POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 15 "THE 5/60"

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY	
NOTE	1601
<p>SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu</p> <p>DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE</p> <p>DON'T HOOK PAPER GUIDE u ON SHEET HOLDER</p> <p>BEWARE OF IMITATIONS</p> <p>BEWARE OF IMITATIONS(Color Style Write</p>	
	1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	CUT(I)
02 WIND AV CORD	COPY(C)
03 SET CRG HOLDER	PASTE(P)
04	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 19

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

097394 01031
"0000" 000000

FIG. 20

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div> <div>CUT(I)</div> <div>COPY(C)</div> <div>PASTE(P)</div> <div>ADD(A)</div> <div>DELETE(D)</div> <div>UNDO</div> <div>REVISE(CHANGE)</div> <div>REVISE(DELETE)</div> </div>
NOTE, STANDARD / REQUIRED QUALITY	

1802





WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	   
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	PART
PRINT FROM LIST	
END(X)	

FIG. 22

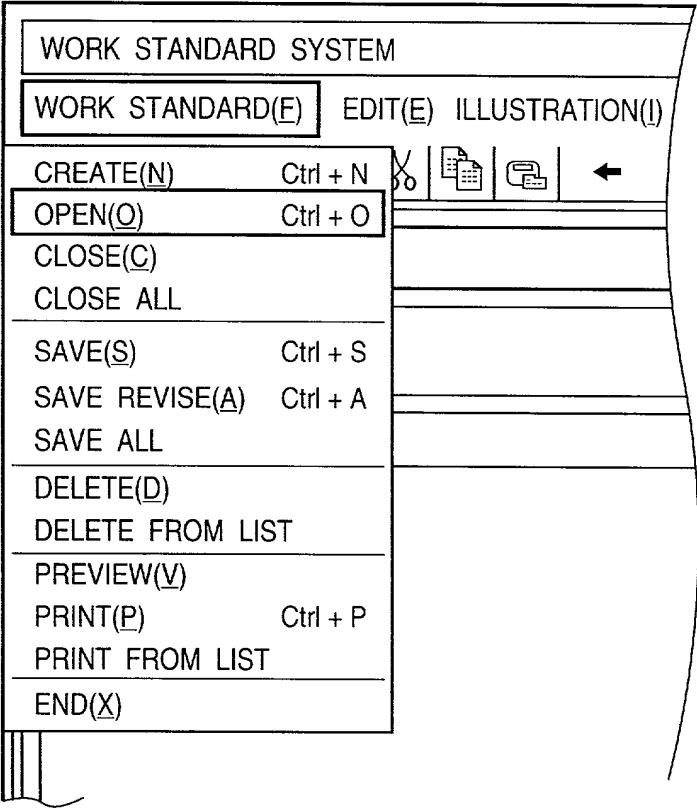


FIG. 23

WORK STANDARD SYSTEM

○ LATEST REVISION NUMBER

○ ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	ASFu取付	1997/09/13
SO-01-01(3)-E	01	ベ-ス・トレーu取付	1997/09/01
SO-01-03-E	01	ベ-ス・トレーu取付	1997/09/01
SO-01-04-E	01	ベ-ス・トレーu取付	1997/09/01

線処理

線処理

線処理

レールグリス塗布





レール取付

SO-06-01-E	01	線処理	1997/09/01
SO-06-02-E	01	線処理	1997/09/01
SO-06-03-E	01	線処理	1997/09/01
SO-07-01(2)-E	01	レールグリス塗布	1997/09/01
SO-08-01-E	01	レール取付	1997/09/01

OK

CANCEL

FIG. 24

SYSTEM					
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)		
		VIEW(V)			
		EDIT(E)			
01 CREATE		PowerPoint			
		✓ Canvas			

09763941.010301

FIG. 25

WORK STANDARD 01 CREATION

APPLIED

PART NUMBER

303

PART NAME

TOOL / TREATMENT DEVICE

WORK PROCEDURE

No.

FILE NAME :

2501

2502

2503

2504

UPDATE

CLEAR

CLOSE

2500

REVISION NUMBER

01

CONTENTS OF REVISION

1997/09/25

DATE

1997/09/25

PERSON IN CHARGE

APPROVE

WORK NAME

MANAGEMENT NO.

FIG. 26

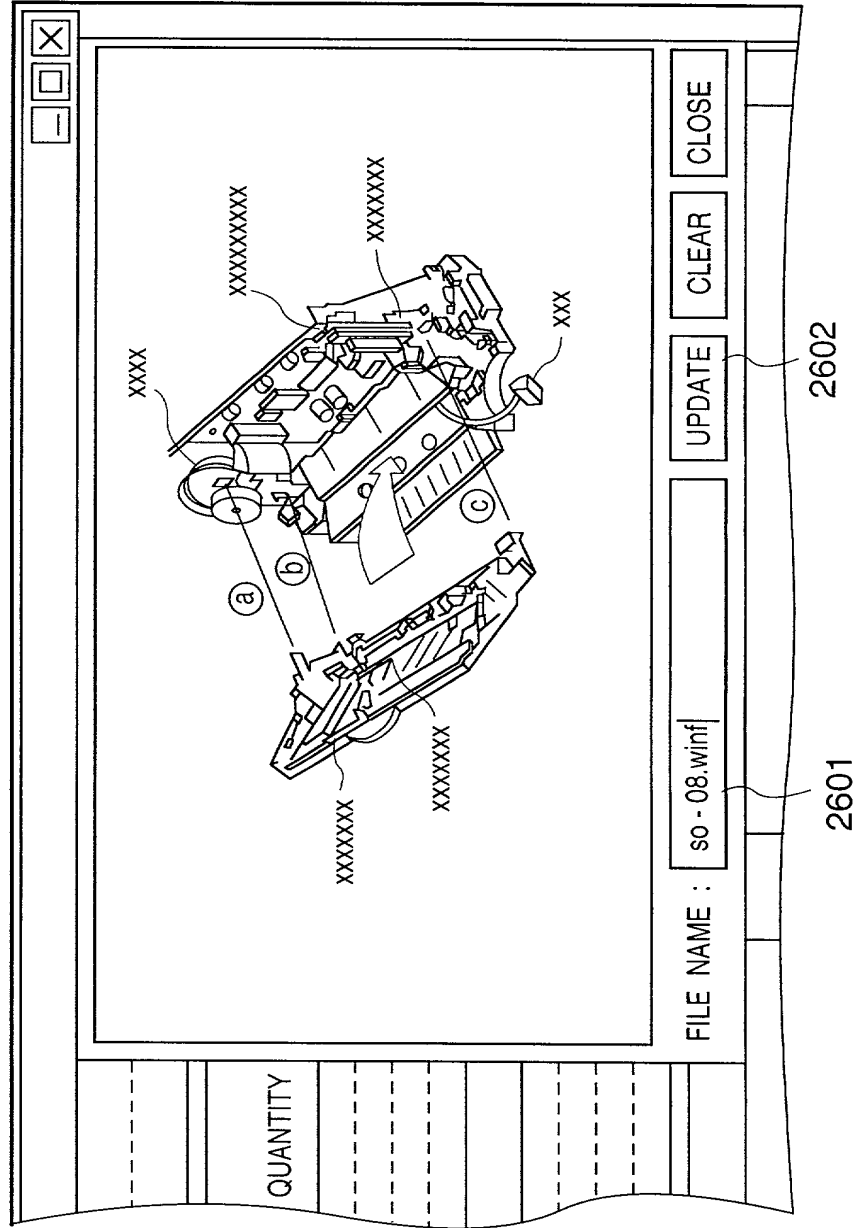


FIG. 27

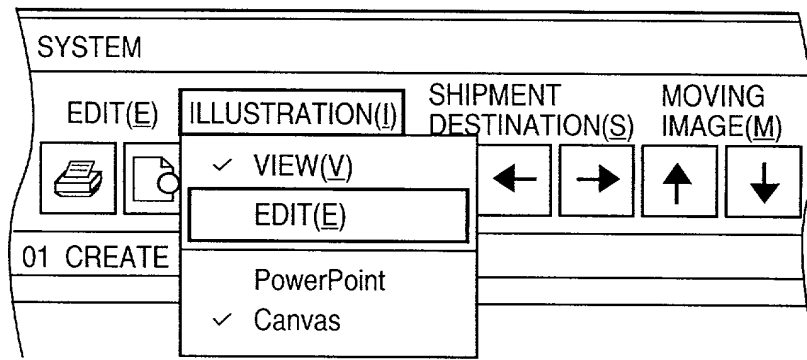


FIG. 28

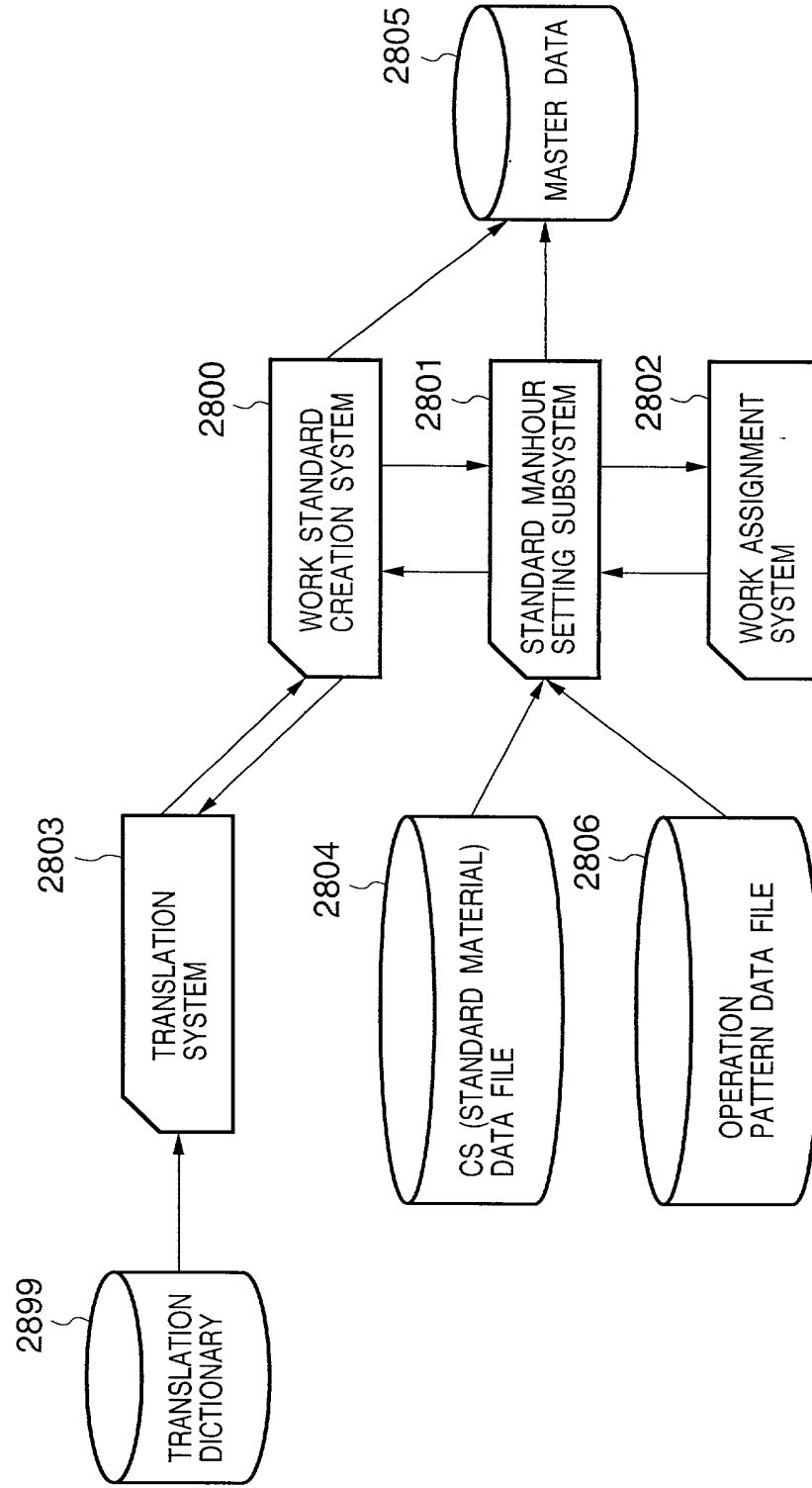


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ ASSEMBLY

☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY DATA

DISPLAY LANGUAGE
☐ JAPANESE
☒ ENGLISH

3000

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	クリーナu取付	X	X
PT - 010 - 020	01	クリーナu取付	X	X
PT - 010 - 030	01	クリーナu取付	X	X
PT - 070 - 030	01	切換アームAssy組立	X	X
PT - 080 - 010	01	伝達ローラu取付	X	X
PT - 090 - 010	01	伝達ローラu取付	X	X
PT - 100 - 010	01	紙押え取付	X	X

3006

3007

3008

3005

3009

SELECT ALL CANCEL SELECT VIEW TRANSLATE TRANSLATE ALL CLOSE

FIG. 31

TRANSLATION OF WORK STANDARD (PROTOTYPE)									
WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W)									
WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT									
Model	QG5-1319								
Part No.	Part Name	Qty	Part No.	Part Name	Qty				
Total						Qty	PN		
No.	Procedure			No.	Precaution / Conditions				
01	The blade lever spring hooks to ① of the blade lever.			02 - 01	No Table Data 1				
02	Side the blade lever in the direction of arrow ② and check there is no catch and nor the return by the spring force.			03 - 01	No Table Data 1				
03	Check press-fitting the blade lever shaft leading edge to the braid folder leading edge.								
Details is of Revision		Data	By	OK					
01	New Created by (PX2056)								
Page No.		PN-030-020							

FIG. 32

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバーネをブレードレバーの ① 部に引っ掛ける

01 ブレードレバーネをブレードレバーの ① 部に引っ掛ける

02 ブレードレバーを矢印 ② 方向にスライドさせ引っ掛かり無くバネ力で戻ることを確認する

03 ブレードレバー軸先端がブレードホルダー先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n...

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

TRANSLATE

OK

CANCEL

3200

3201

3202

3203

3204

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		[X] [X]	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S) POW(W)	
WORK STANDARD PN-030-020 01 New		PLAY(P) X2056) A252 PLATEN UNIT	
Model QG5-1317		NEW(N)	
		DRIVE(D)	

FIG. 34

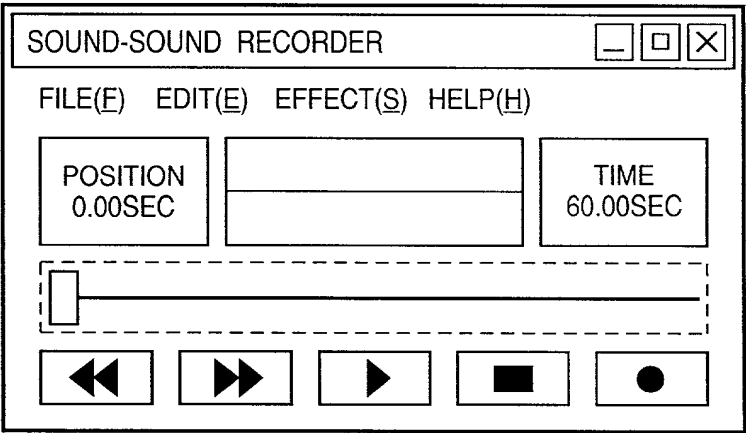


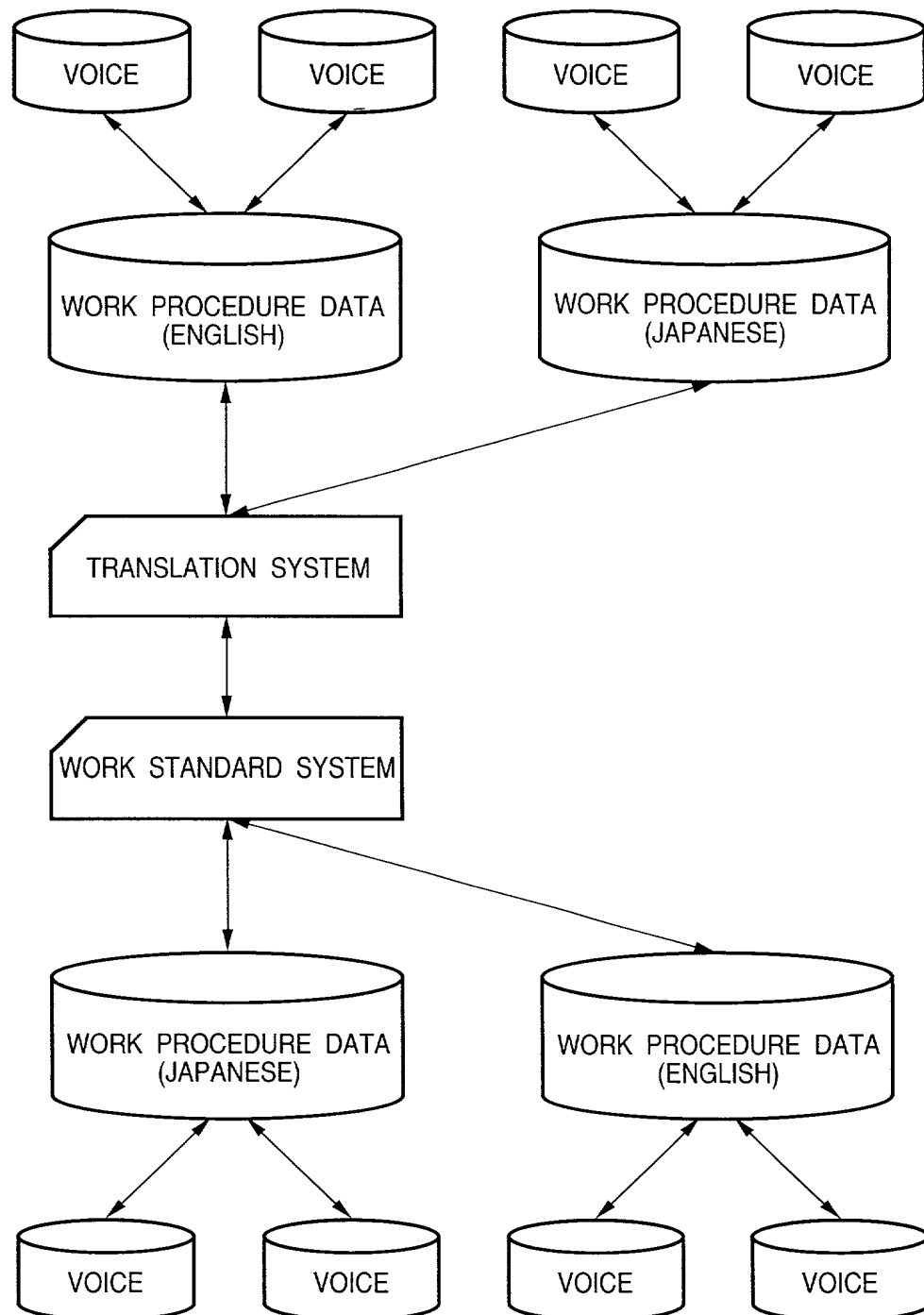
FIG. 35

FIG. 36

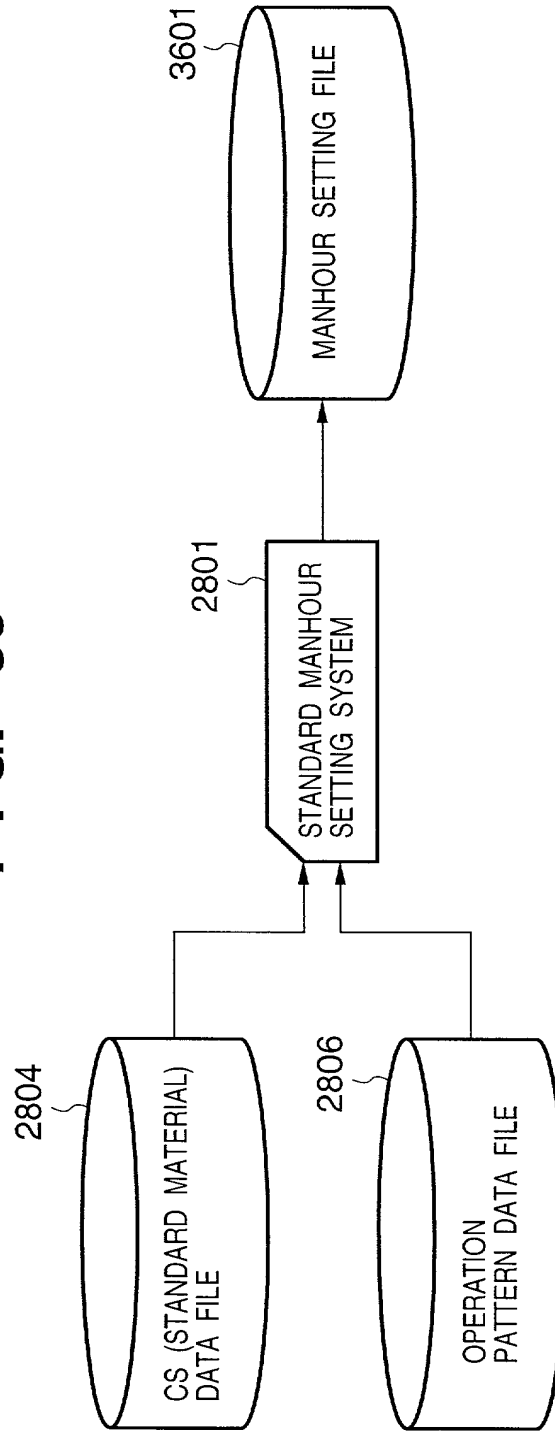


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

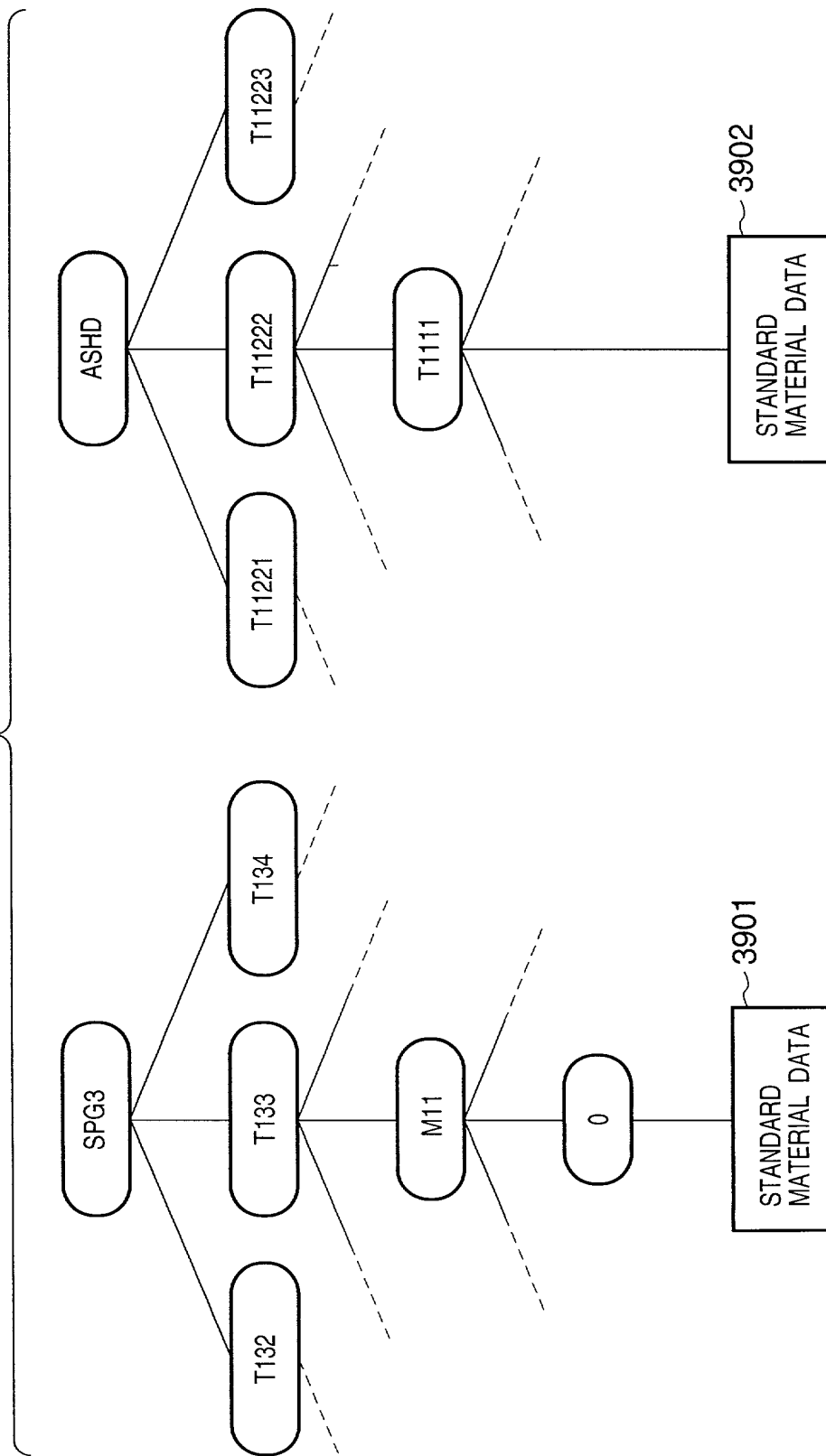
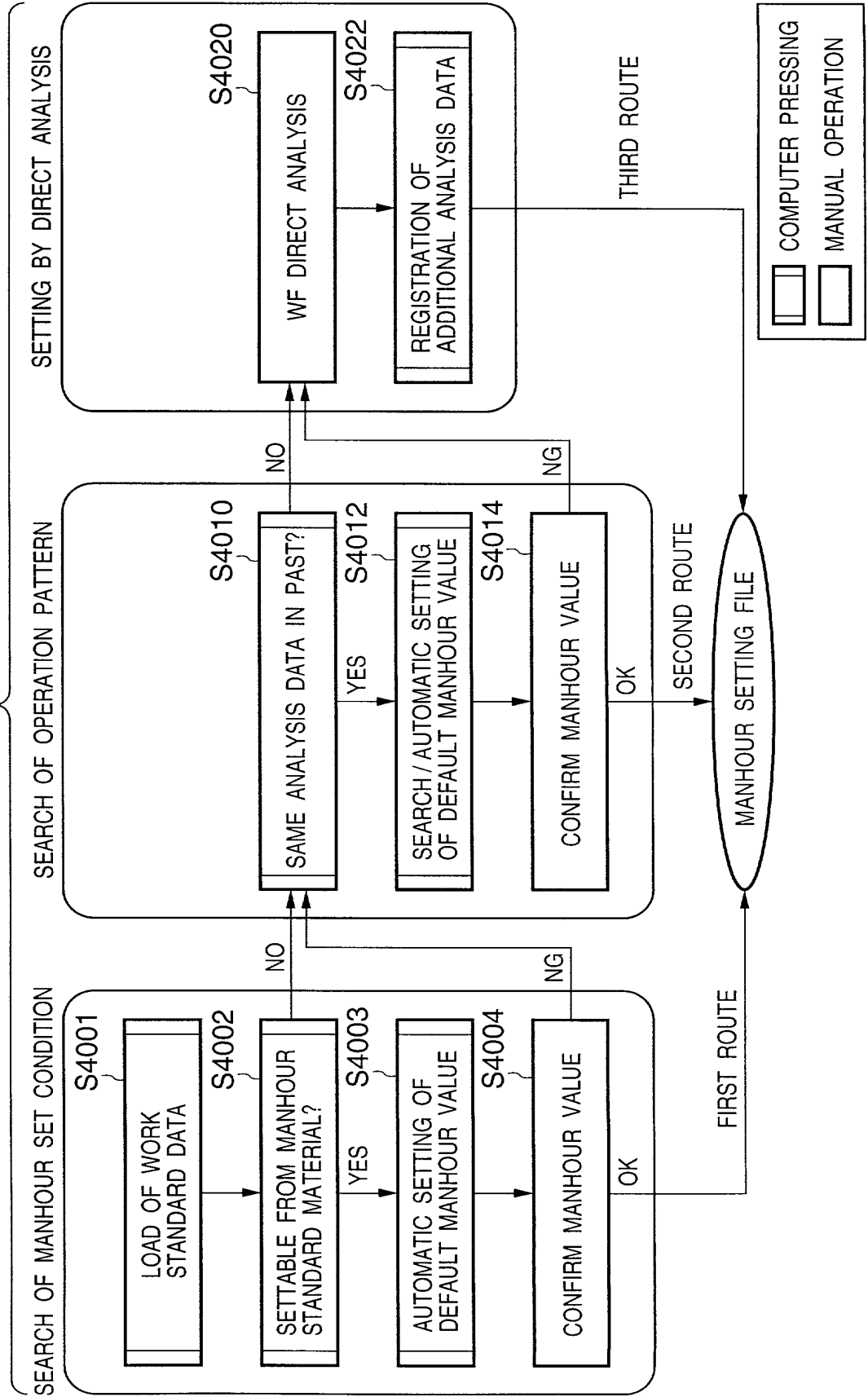


FIG. 40



[illegible]

● ELEMENT WORK NAME

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷バネを	負荷バネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ロー軸を	負荷バネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ロー軸を	治具より	外す

FIG. 42

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	負荷ハネを負荷ハネ取付治具に組込む (SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / 0
2	治具のSWをONにする (TURN ON SW OF TREATMENT DEVICE)	1	1	8		
3	分離ロー軸を負荷ハネ取付治具に取込む (SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111
4	治具のSWをOFFにする (TURN OFF SW OF TREATMENT DEVICE)	1	1	8		
5	分離ロー軸を治具より外す (DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*ハネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*リンクを	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネクタを	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

2804

MATCH2806 

2020

3601

[illegible]

FIG. 45

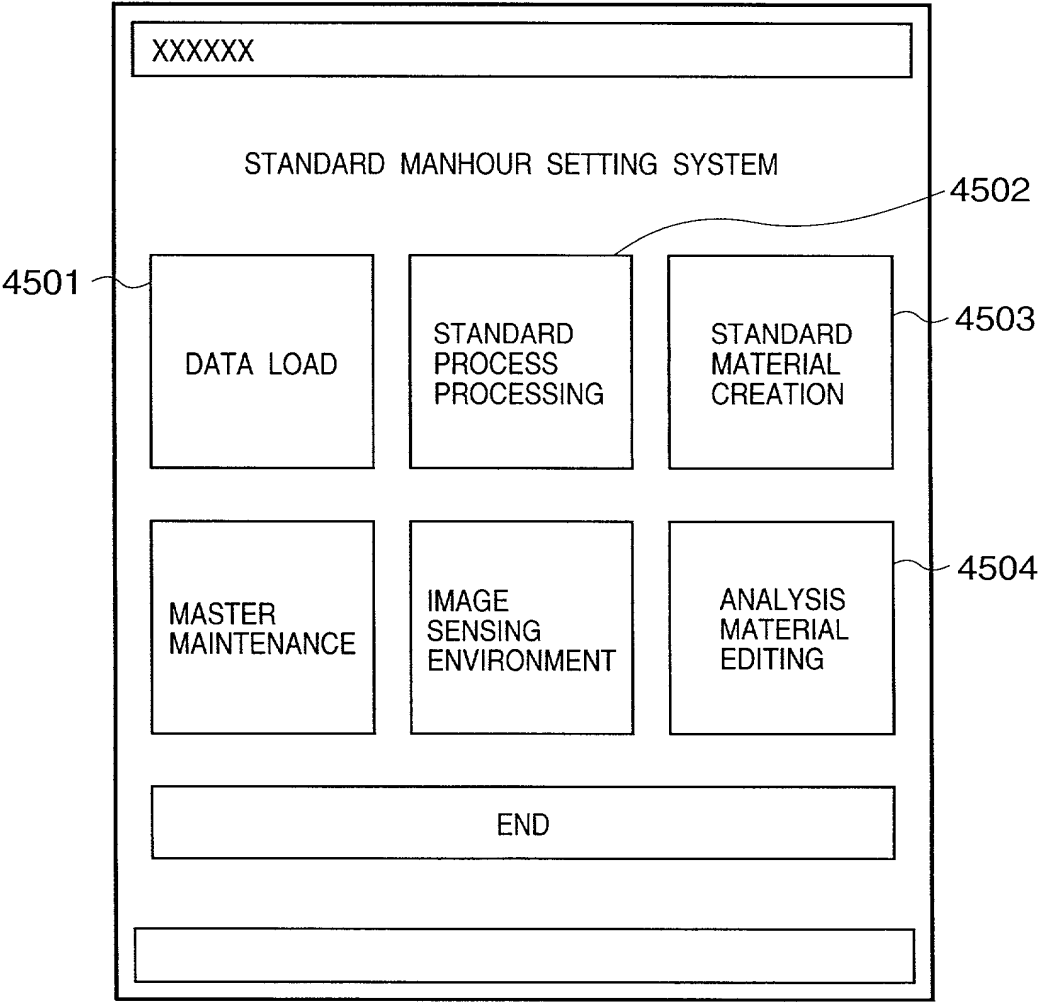


FIG. 45

FIG. 46

4609 4610

XXXXXXX

☒ ALL ☐ DESIGNATE : 4612

PRODUCT NUMBER : NAME :

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL - OLD	SET IN 1996	
xyz - test				
test - 01				
tesr - AMI				

4601

4605

4602 4603 4604

FIG. 47

[illegible]

FIG. 48

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4800

4801

4802

4803

4804

4805

4806

FIG. 48

FIG. 49

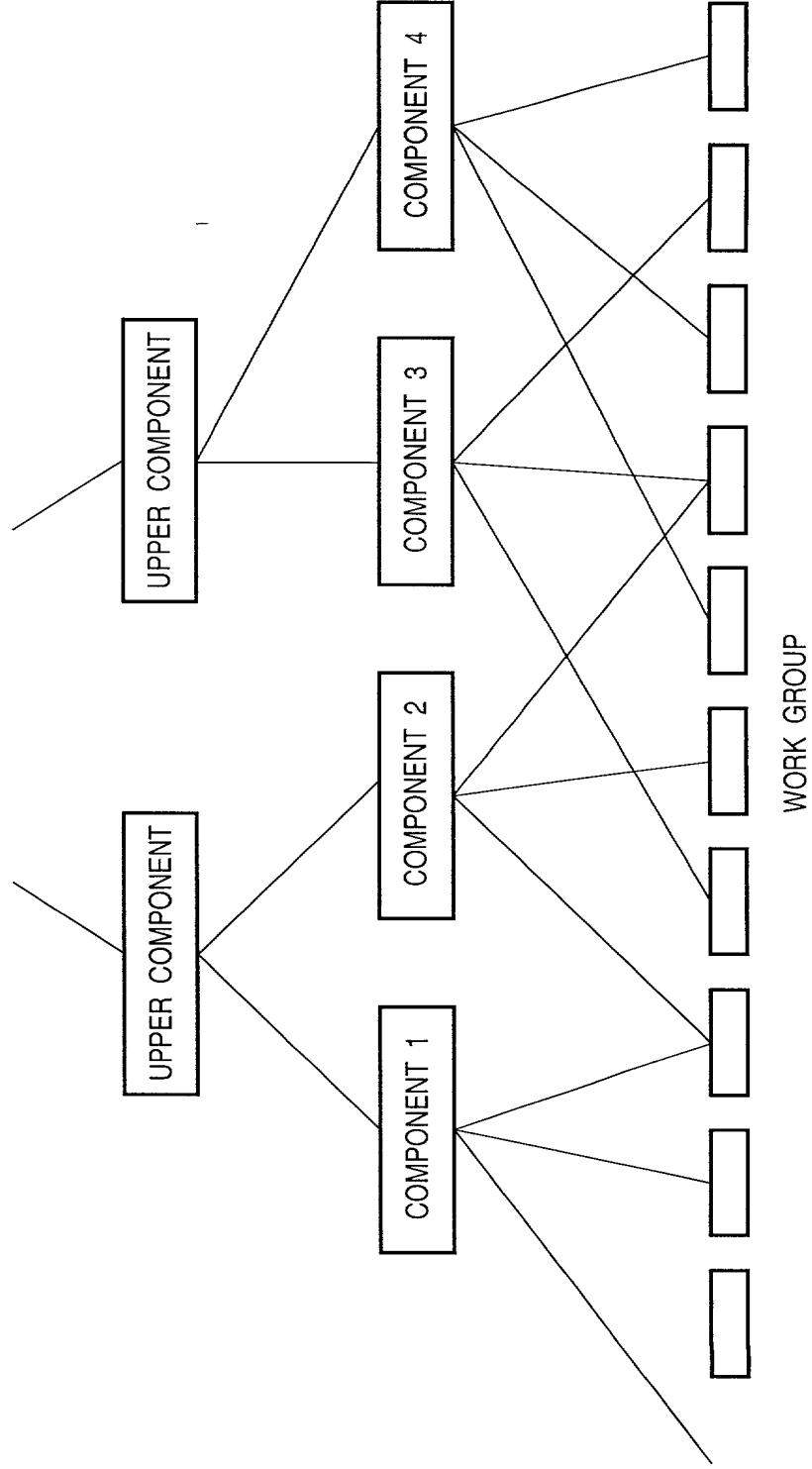


FIG. 50

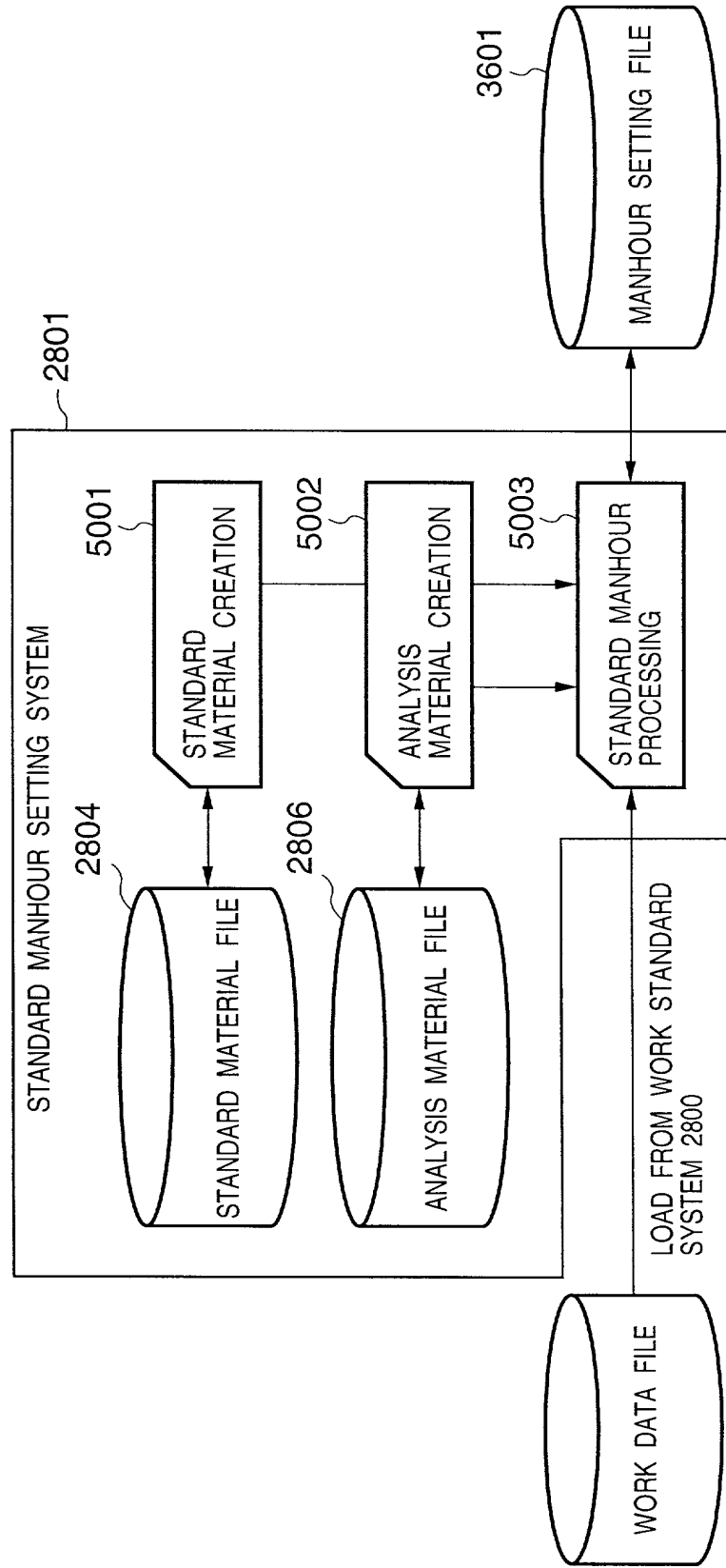


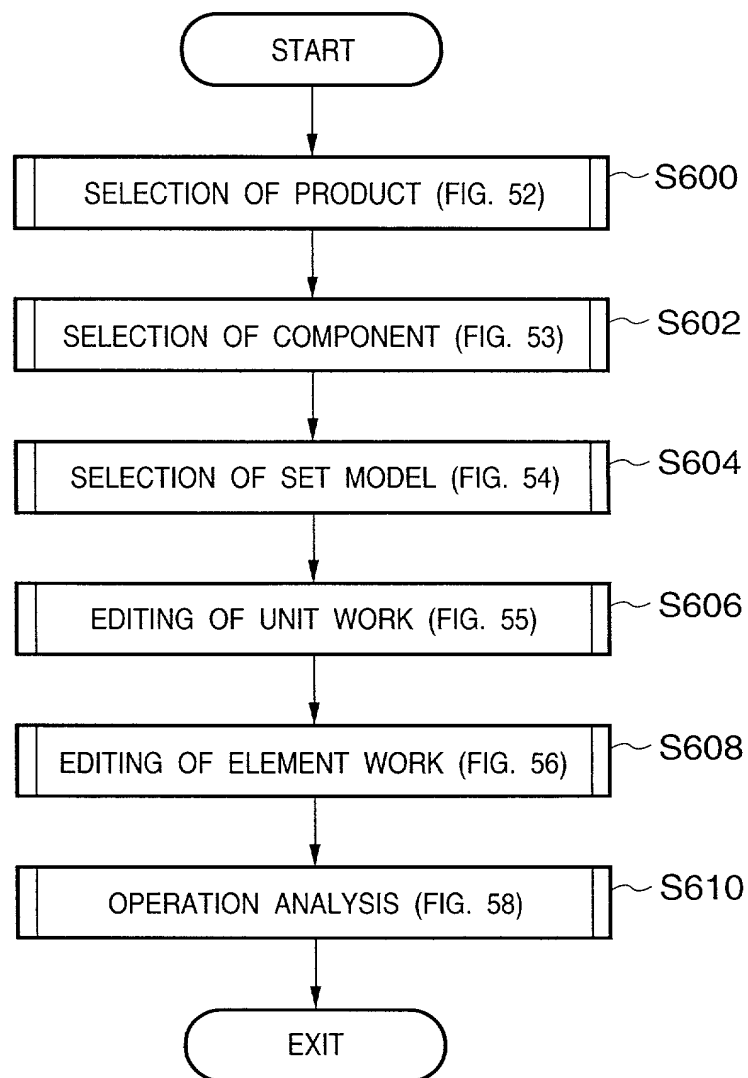
FIG. 51

FIG. 52

SELECTION OF PRODUCT			
FILE(F) EDIT(E)			

5201

FIG. 53

SELECTION OF COMPONENT			
FILE(E) EDIT(E)			
<div style="float: right; text-align: right;">NAME : BJ - 4200</div> <div style="clear: both;"></div>			
PRODUCT SYMBOL : BJ - 4200			
COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE	
▲ BK	XXXXX	1997/09/22 11:09:59	
CH	CHECK PROCESS	1997/09/12 11:09:59	
KO	PACKAGE	1997/09/18 11:21:07	
I			
<div style="float: right; text-align: right;">END</div> <div style="clear: both;"></div>			

NEXT DOWNLOAD UPLOAD BACK UP LIST CANCEL ACCESS FLAG END

COMPONENT SYMBOL : ON	NAME :	NAME : XXXXXX
-----------------------	--------	---------------

LATEST
REVISION NUMBER

S		FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY
▲	Ni 3	CH-01-01	1	電気チェック	0	0	0	1
	Ni 4	CH-01-02(1)	1	電気チェック	0	0	0	1
	Ni 5	CH-01-02(2)	1	電気チェック	0	0	0	1
	Ni 6	CH-01-03	1	電気チェック	0	0	0	1
	Ni 7	CH-01-04	1	電気チェック	0	0	0	1

Ni	23	CH-07-02(1)	1	フロントカバーu取付	0	0	0	1
Ni	24	CH-07-02(2)	1	フロントカバーu取付	0	0	0	1
Ni	25	CH-07-01(3)	1	フロントカバーu取付	0	0	0	1
Ni	26	CH-07-01(4)	1	フロントカバーu取付	0	0	0	1

UNIT WORK NAME	MANHOUR	USE / FREQUENCY	1	2	3	4	5
----------------	---------	-----------------	---	---	---	---	---

[illegible]

OK

5501 5507 5506 5502 5503 5504 5505

FIG. 56









XXXXXX									
       									
FORMAL MANAGEMENT NO. PU-03-01				UNIT WORK NAME: MOTOR ATTACHMENT		TOTAL MANHOUR: 0		NEXT UNIT WORK	
NO.	ELEMENT WORK NAME	REVISION	MANHOUR	USE	CS	SET CONDITION			
▶ 1	LFモータのケージと反対側の軸にダブルギア	1	0	0					
*									
<p>COMMENT 1 : LFモータのケージと反対側の軸に</p> <p>OBJECT : ダブルギアを</p> <p>COMMENT 2 : ギア径の小さい方から</p> <p>VERB : 取付ける</p>									

FIG. 57

EDITING OF ANALYSIS MATERIAL



FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE : ALL ▼

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USE	FREQUENCY	COUNT	SET DATE
▶	I7-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/09 9:52
	I7-キャップ:	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0	1	0	97/09/09 9:53
	I7-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/09 9:55
		要素作業01		動詞	-50/Gr1/N/>6/-3	15	0	1	0	97/09/10 16:34
	I7-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/10 19:09
		キャリッジロック		塗布する	Time100/Rate100	100	100	1	1	97/09/10 19:16
	モータ組立:	フリンダジャー		入れ、セットする	M211/1/10	50	1	1	1	97/09/11 17:00
		フリンダジャー		裏面にする	T1221/M2311/0/0	12	0	1	0	97/09/11 17:34
		1		1	T2221/M1211/0/1	24	0	1	0	97/09/11 17:20
		2		2	T1221/M2311/0/0	12	0	1	0	97/09/11 17:24
		フリンダジャー	PRカット`取付る	セットする		15	0	1	0	97/09/12 11:24
		dgdafdfas		fdasfdasfdasfd	*	16	0	1	0	97/09/12 12:10
		dsosfisdasfd		fdasfdaddfdas	T21121/M1111/0/1	13	0	1	0	97/09/12 12:10
		dgdafdfas		fdasfdasfdasfd	*	16	0	1	0	97/09/12 13:39
		フリンダジャー	PRカット`取付る	セットする		15	0	1	0	97/09/12 14:00
		フリンダジャー	PRカット`取付る	セットする		15	0	1	0	97/09/12 14:00
		フリンダユニット		セットする	Time100/Rate100	100	100	1	0	97/09/12 14:04

FIG. 59

5901

☐ 1. PU

☐ 2. GET

☐ 3. M

☐ 4. MA

☐ 5. ASY

☐ 6. DSY

☐ 7. R

☐ 8. UMAC

☐ 9. MP

☐ 10. BODY

☐ 11. PU

☐ 12. GET

☐ 13. M

☐ 14. MA

☐ 15. ASY

☐ 16. DSY

☐ 17. R

☐ SIMO

SELECT

CANCEL

5902

FIG. 60

XXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					
6 :										

SET

CANCEL

SET VALUE

FORMULA

6001

6002

6003

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET

CANCEL

SET VALUE

6102 6105

6101 6104 6103

FIG. 62

INQUIRY OF LOG

VARIATION AMOUNT : 10

USE : 0

REASON CODE : 1

CHANGE REASON : SET ▼

OK Clear

6201 6202 6203 6204 6205 6206

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE

1997

09

22

☐ = ☐ FROM

☒ BEFORE ☐ ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOURL	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOURL	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14:30.00

REASON CODE

1

CHANGE REASON

SET

▼

OK

Ctrl

END

FIG. 64

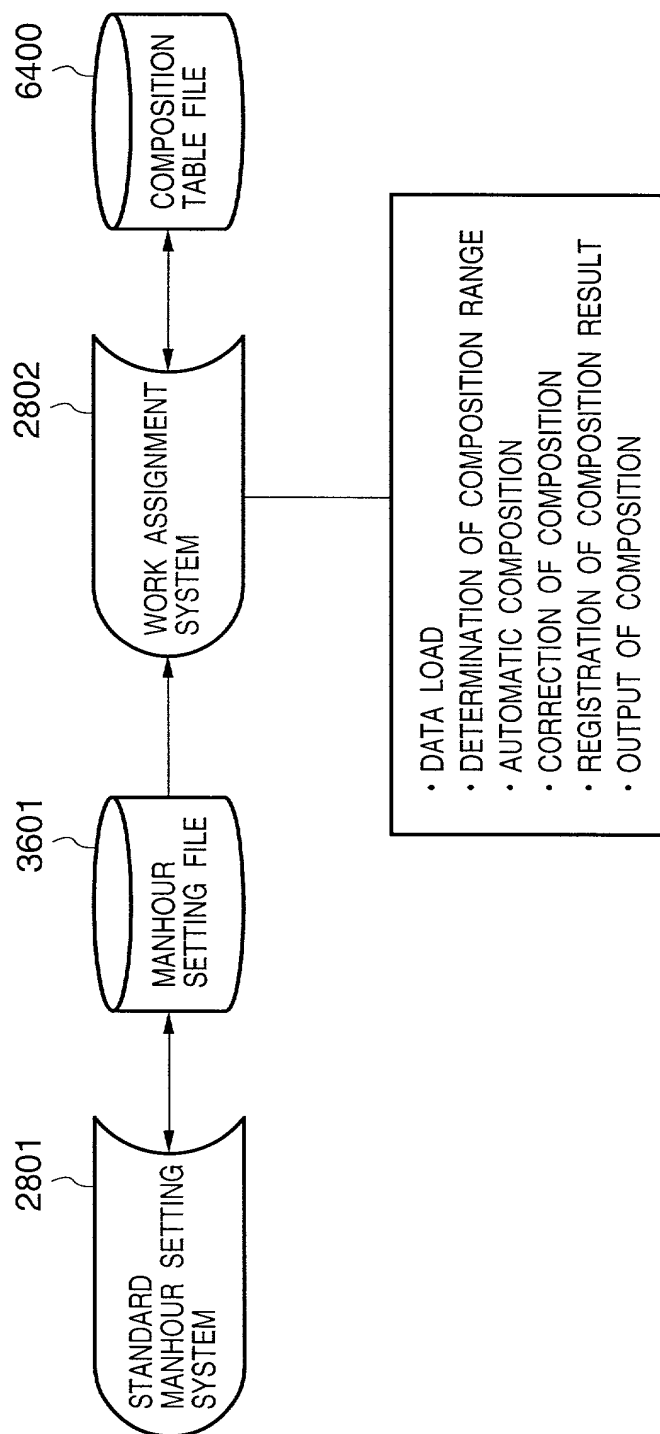


FIG. 65

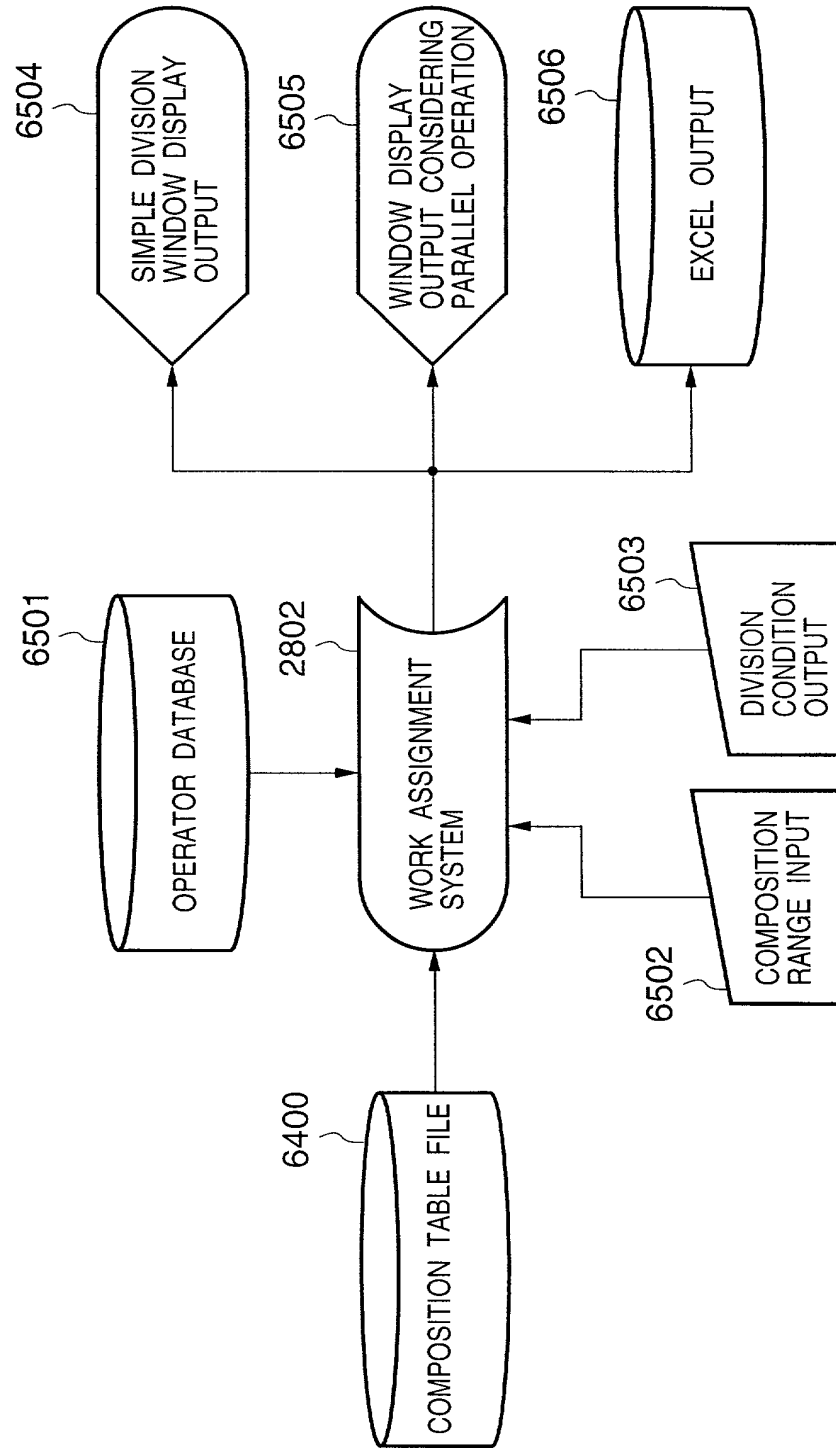


FIG. 66

WORK ORDER

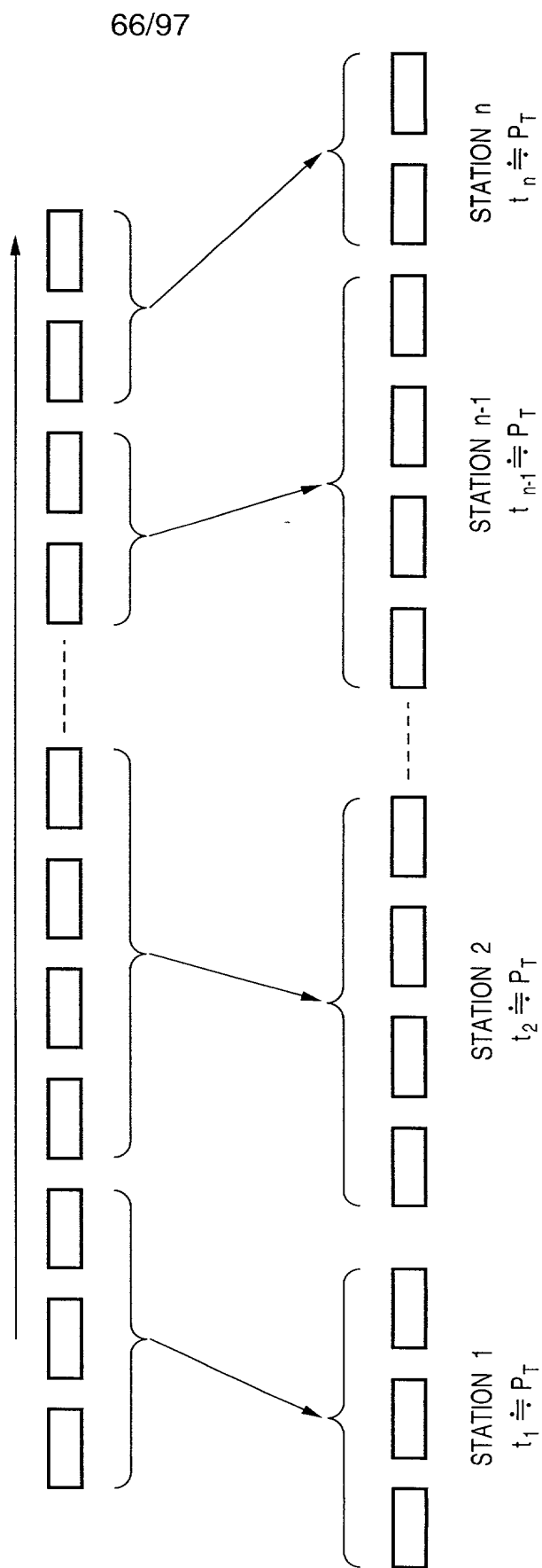


FIG. 67

FILE(F) EDIT(E) INPUT(I) TOOL(O)

MODEL

GP55

UNIT

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

: :

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
	FILE(F) EDIT(E)		◆
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69

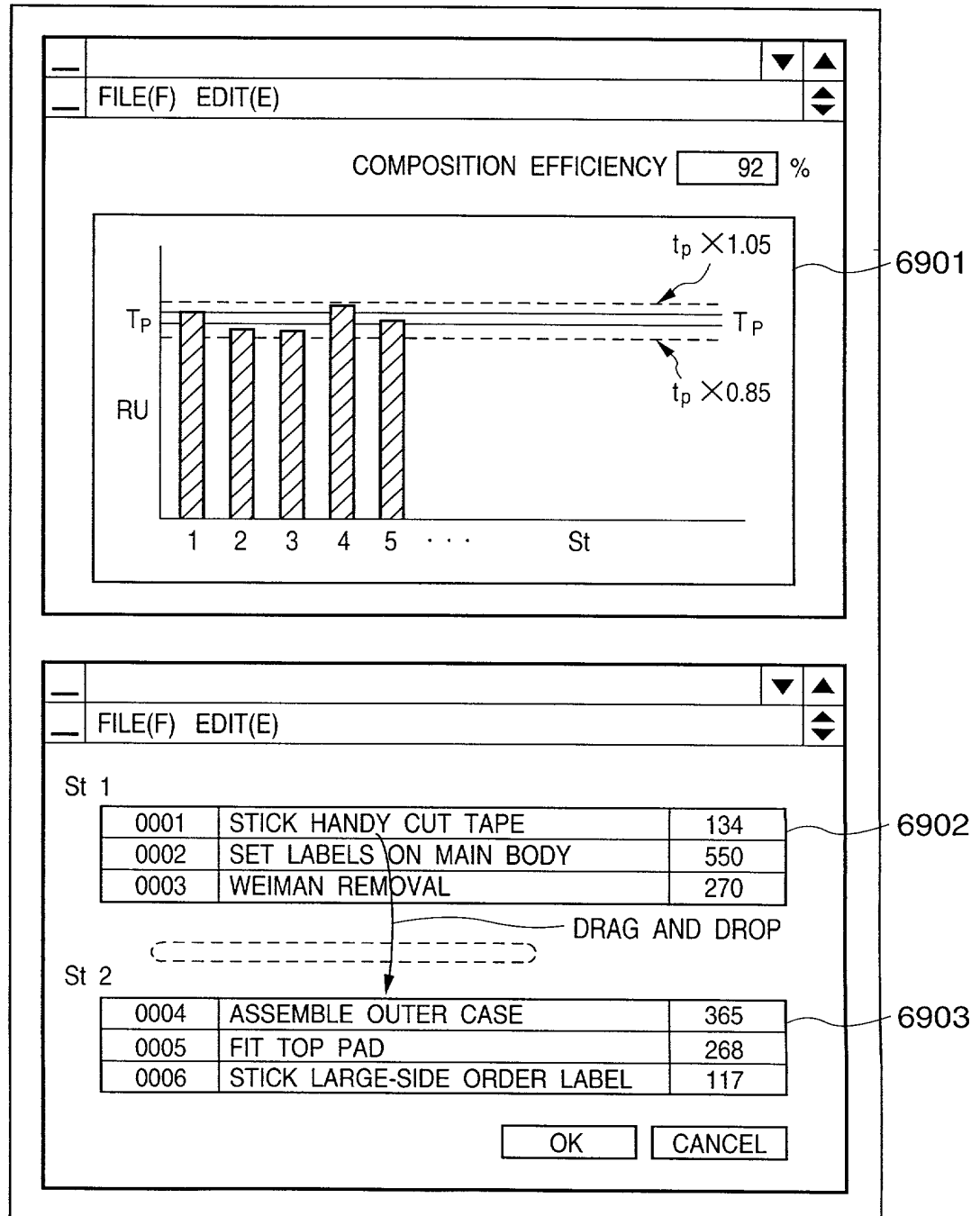
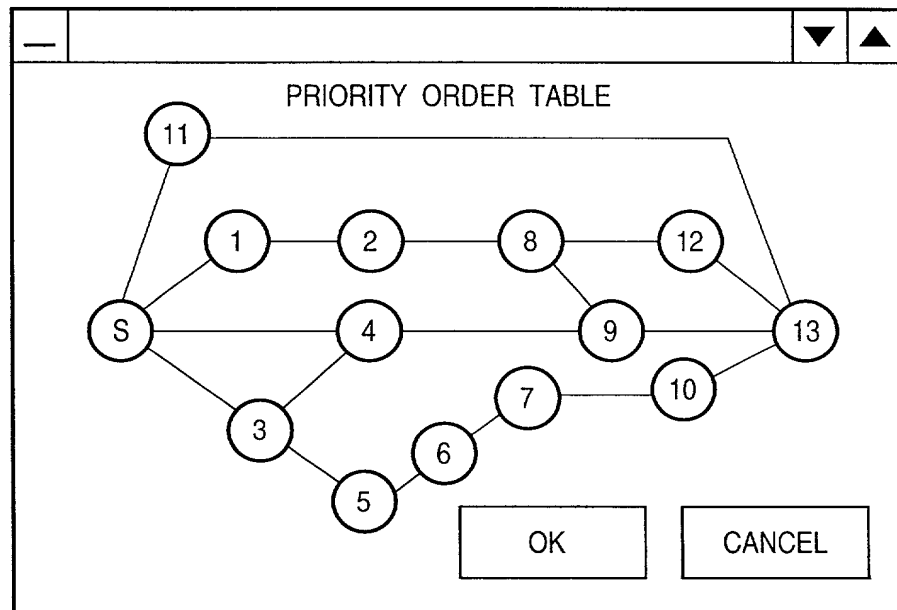


FIG. 70

PARALLEL DIVISION

```

graph TD
    PLAN1[PLAN 1] --> PLAN2[PLAN 2]
    PLAN1 --> PLAN3[PLAN 3]
    PLAN2 --> St1[St 1]
    PLAN2 --> St2[St 2]
    St1 --> T1["1 STICK HANDY CUT TAPE (99)"]
    St1 --> T2["2 SET LABELS ON MAIN BODY (78)"]
    St1 --> T3["3 WEIMAN REMOVAL (134)"]
    St2 --> T4["4 ASSEMBLE OUTER CASE (732)"]
    St2 --> T5["5 FIT TOP PAD (268)"]
    St2 --> T6["6 STICK LARGE-SIDE ORDER LABEL (117)"]
    PLAN3 --> St3[St 3]
    PLAN3 --> St4[St 4]
    St3 --> T7["7 ASSEMBLE MAIN BODY (100)"]
    St3 --> T8["8 ASSEMBLE MAIN BODY (100)"]
    St4 --> T9["9 ASSEMBLE MAIN BODY (100)"]
    St4 --> T10["10 ASSEMBLE MAIN BODY (100)"]
  
```

FIG. 72

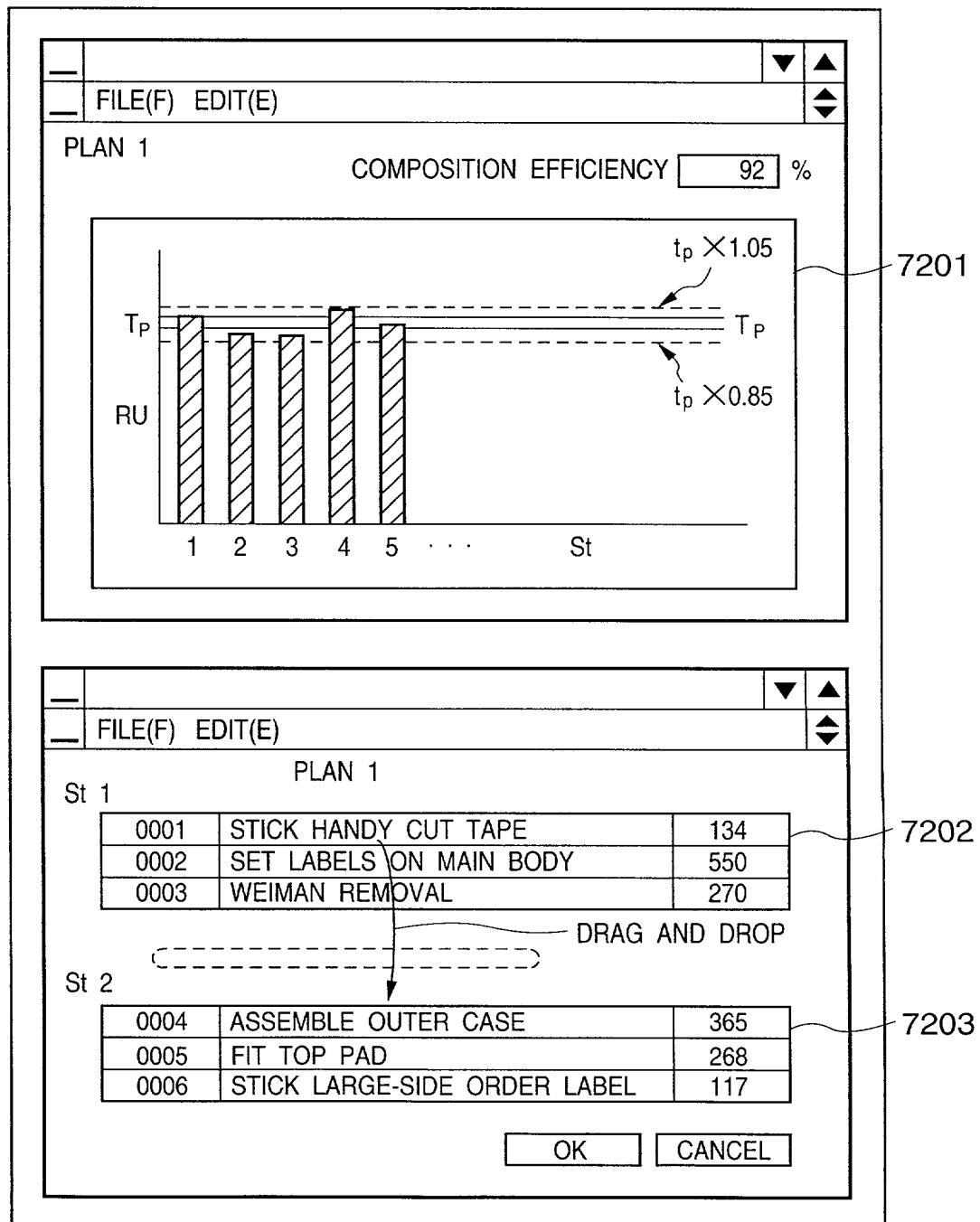


FIG. 73

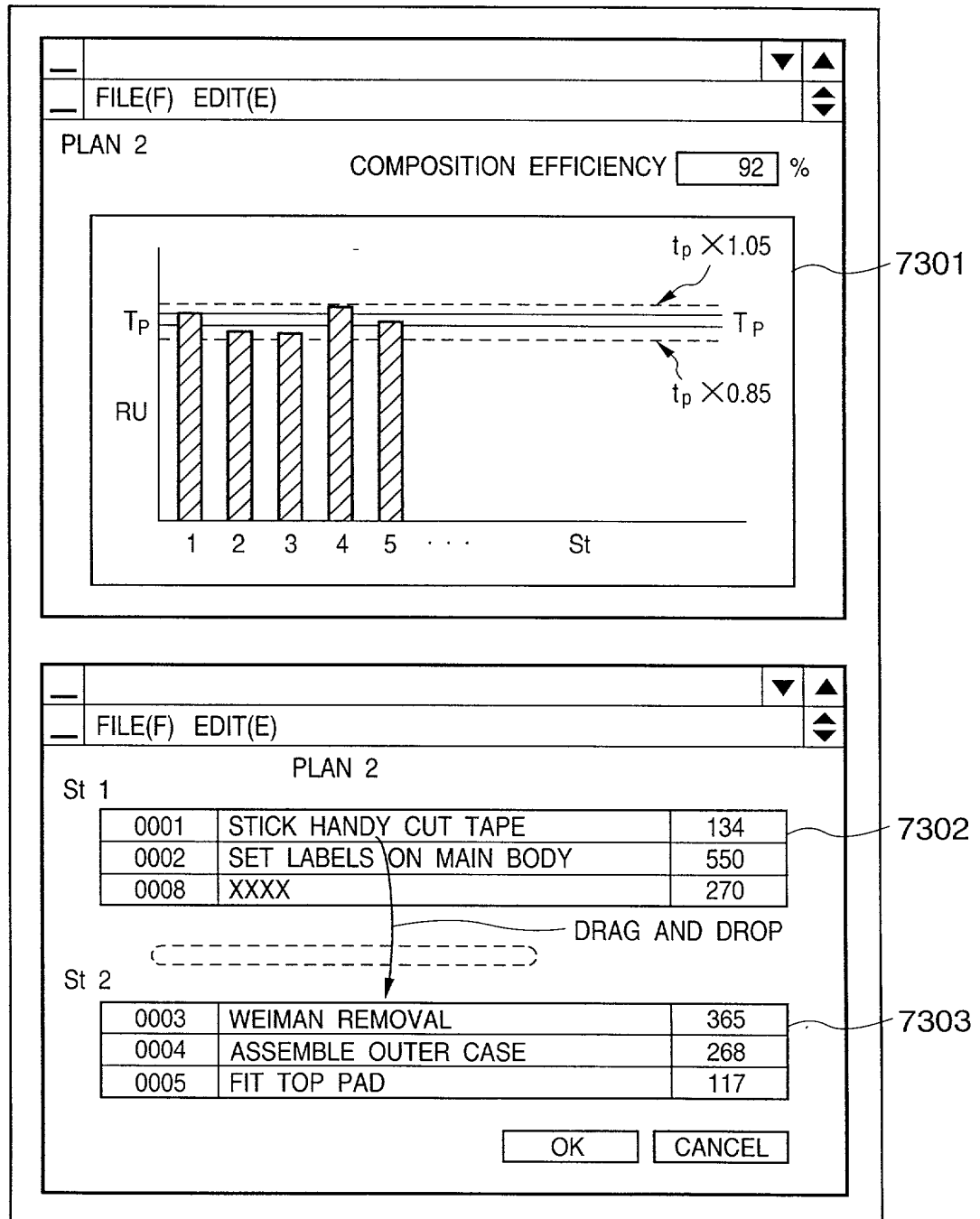


FIG. 74

7401

7402

7403

7404

7405

7406

7407

7409

74/97

7408

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

GENRE

BJ
FAX
LBP
NP
STAND

REPRESENTATIVE
MODEL

TARGET MODEL

COMPONENT

COMPONENT SYMBOL	COMPONENT NAME	ORDER

OK

CANCEL

FIG. 75

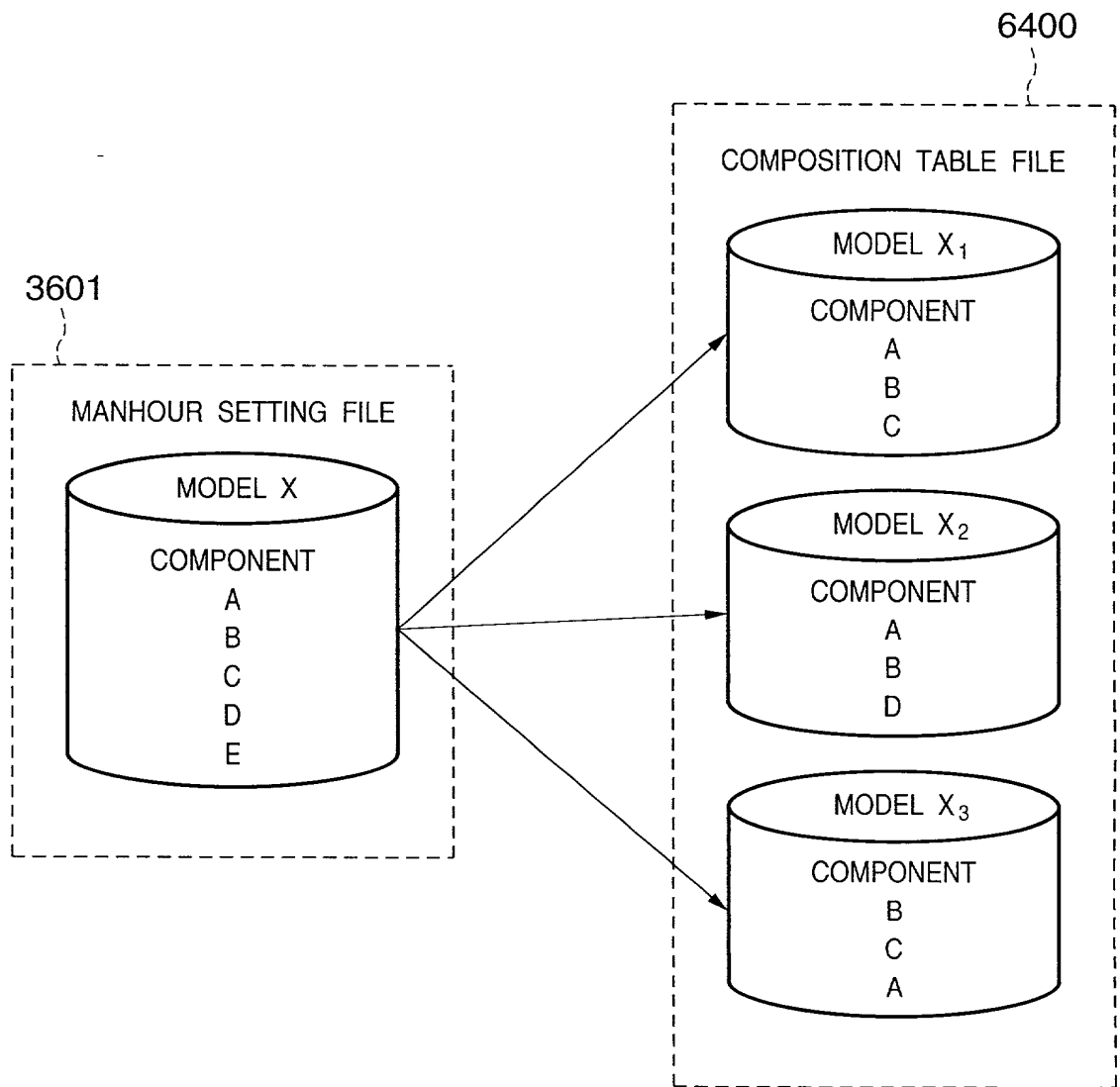


FIG. 76

7601

7602

7603

7604

7605

7606

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

f12-0010.csv	テストデータ(元)	1	97/09/19 12:00:34
f12-0010.csv	テスト	0	97/09/19 13:27:17
BJC-4300	0	0	97/09/19 14:10:14
BJC-4300	0	0	97/09/19 14:10:32
BJC-4300	0	1	97/09/19 15:41:14
BJC-4300	BJC-4300Aライン編成	03	97/09/20 14:16:58
BJC-4300	BJC-4300Aライン編成	00	97/10/13 17:54:57
BJC-4300	BJC-4300Aライン編成	00	97/09/20 14:06:36
f12-0010.csv	f12-0010Aライン編成	05	97/09/24 17:11:53

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

1

FIG. 78

INSERTION OF UNIT WORK ✕

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

REMARKS :

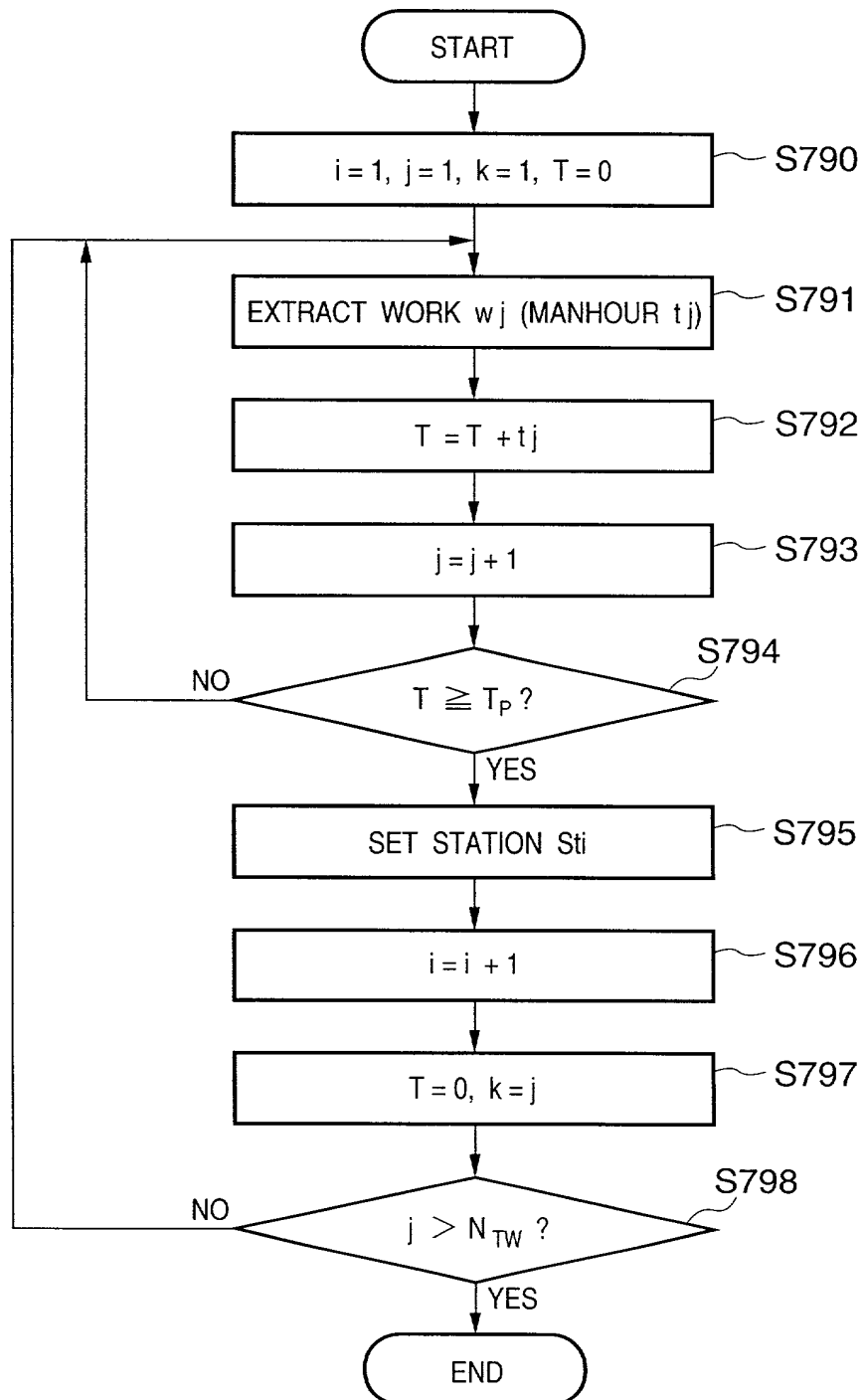
FIG. 79

FIG. 80

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

OPERATOR 2

OPERATOR 3

OPERATOR 4

OPERATOR 5

8001

8002

8003

8009

8008

8004

8005

8006

OPERATOR 1				OPERATOR 2				OPERATOR 3				OPERATOR 4				OPERATOR 5								
S11				S12				S13				S14				S15								
UNIT	NAME	WF	MAN-CHINE	UNIT	NAME	WF	MAN-CHINE	UNIT	NAME	WF	MAN-CHINE	UNIT	NAME	WF	MAN-CHINE	UNIT	NAME	WF	MAN-CHINE					
UNIT	NAMEu1	63	0	9000	UNIT	NAMEu1	63	0	9000	UNIT	NAMEu9	144	0	9000	UNIT	NAMEu13	33	0	9000	UNIT	NAMEu20	250	0	9000
UNIT	NAMEu2	30	0	9000	UNIT	NAMEu2	30	0	9000	UNIT	NAMEu10	16	0	9000	UNIT	NAMEu14	72	0	9000	UNIT	NAMEu21	0	0	9000
UNIT	NAMEu3	156	0	9000	UNIT	NAMEu3	156	0	9000	UNIT	NAMEu11	293	0	9000	UNIT	NAMEu15	35	0	9000	UNIT	NAMEu22	50	0	9000
UNIT	NAMEu4	35	0	9000	UNIT	NAMEu4	35	0	9000	UNIT	NAMEu12	133	0	9000	UNIT	NAMEu16	56	0	9000	UNIT	NAMEu23	55	0	9000
UNIT	NAMEu5	50	0	9000	UNIT	NAMEu5	50	0	9000	UNIT	NAMEu13	150	0	9000	UNIT	NAMEu17	150	0	9000	UNIT	NAMEu24	88	0	9000
UNIT	NAMEu6	201	xxx	LOCK	UNIT	NAMEu6	201	xxx	LOCK	UNIT	NAMEu14	16	0	9000	UNIT	NAMEu18	16	0	9000	UNIT	NAMEu25	147	0	9000
UNIT	NAMEu7	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu7	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu15	250	0	9000	UNIT	NAMEu19	250	0	9000	UNIT	NAMEu26	52	0	9000
UNIT	NAMEu8	285	xxx	xxx LOCK	UNIT	NAMEu8	285	xxx	xxx LOCK	UNIT	NAMEu16	150	0	9000	UNIT	NAMEu20	150	0	9000	UNIT	NAMEu27	55	0	9000
UNIT	NAMEu9	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu9	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu17	150	0	9000	UNIT	NAMEu21	150	0	9000	UNIT	NAMEu28	55	0	9000
UNIT	NAMEu10	201	xxx	LOCK	UNIT	NAMEu10	201	xxx	LOCK	UNIT	NAMEu18	16	0	9000	UNIT	NAMEu22	16	0	9000	UNIT	NAMEu29	55	0	9000
UNIT	NAMEu11	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu11	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu19	250	0	9000	UNIT	NAMEu23	250	0	9000	UNIT	NAMEu30	55	0	9000
UNIT	NAMEu12	285	xxx	xxx LOCK	UNIT	NAMEu12	285	xxx	xxx LOCK	UNIT	NAMEu20	150	0	9000	UNIT	NAMEu24	150	0	9000	UNIT	NAMEu31	55	0	9000
UNIT	NAMEu13	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu13	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu21	150	0	9000	UNIT	NAMEu25	150	0	9000	UNIT	NAMEu32	55	0	9000
UNIT	NAMEu14	201	xxx	LOCK	UNIT	NAMEu14	201	xxx	LOCK	UNIT	NAMEu22	150	0	9000	UNIT	NAMEu26	150	0	9000	UNIT	NAMEu33	55	0	9000
UNIT	NAMEu15	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu15	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu23	150	0	9000	UNIT	NAMEu27	150	0	9000	UNIT	NAMEu34	55	0	9000
UNIT	NAMEu16	285	xxx	xxx LOCK	UNIT	NAMEu16	285	xxx	xxx LOCK	UNIT	NAMEu24	150	0	9000	UNIT	NAMEu28	150	0	9000	UNIT	NAMEu35	55	0	9000
UNIT	NAMEu17	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu17	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu25	150	0	9000	UNIT	NAMEu29	150	0	9000	UNIT	NAMEu36	55	0	9000
UNIT	NAMEu18	201	xxx	LOCK	UNIT	NAMEu18	201	xxx	LOCK	UNIT	NAMEu26	150	0	9000	UNIT	NAMEu30	150	0	9000	UNIT	NAMEu37	55	0	9000
UNIT	NAMEu19	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu19	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu27	150	0	9000	UNIT	NAMEu31	150	0	9000	UNIT	NAMEu38	55	0	9000
UNIT	NAMEu20	285	xxx	xxx LOCK	UNIT	NAMEu20	285	xxx	xxx LOCK	UNIT	NAMEu28	150	0	9000	UNIT	NAMEu32	150	0	9000	UNIT	NAMEu39	55	0	9000
UNIT	NAMEu21	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu21	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu29	150	0	9000	UNIT	NAMEu33	150	0	9000	UNIT	NAMEu40	55	0	9000
UNIT	NAMEu22	201	xxx	LOCK	UNIT	NAMEu22	201	xxx	LOCK	UNIT	NAMEu30	150	0	9000	UNIT	NAMEu34	150	0	9000	UNIT	NAMEu41	55	0	9000
UNIT	NAMEu23	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu23	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu31	150	0	9000	UNIT	NAMEu35	150	0	9000	UNIT	NAMEu42	55	0	9000
UNIT	NAMEu24	285	xxx	xxx LOCK	UNIT	NAMEu24	285	xxx	xxx LOCK	UNIT	NAMEu32	150	0	9000	UNIT	NAMEu36	150	0	9000	UNIT	NAMEu43	55	0	9000
UNIT	NAMEu25	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu25	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu33	150	0	9000	UNIT	NAMEu37	150	0	9000	UNIT	NAMEu44	55	0	9000
UNIT	NAMEu26	201	xxx	LOCK	UNIT	NAMEu26	201	xxx	LOCK	UNIT	NAMEu34	150	0	9000	UNIT	NAMEu38	150	0	9000	UNIT	NAMEu45	55	0	9000
UNIT	NAMEu27	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu27	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu35	150	0	9000	UNIT	NAMEu39	150	0	9000	UNIT	NAMEu46	55	0	9000
UNIT	NAMEu28	285	xxx	xxx LOCK	UNIT	NAMEu28	285	xxx	xxx LOCK	UNIT	NAMEu36	150	0	9000	UNIT	NAMEu40	150	0	9000	UNIT	NAMEu47	55	0	9000
UNIT	NAMEu29	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu29	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu37	150	0	9000	UNIT	NAMEu41	150	0	9000	UNIT	NAMEu48	55	0	9000
UNIT	NAMEu30	201	xxx	LOCK	UNIT	NAMEu30	201	xxx	LOCK	UNIT	NAMEu38	150	0	9000	UNIT	NAMEu42	150	0	9000	UNIT	NAMEu49	55	0	9000
UNIT	NAMEu31	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu31	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu39	150	0	9000	UNIT	NAMEu43	150	0	9000	UNIT	NAMEu50	55	0	9000
UNIT	NAMEu32	285	xxx	xxx LOCK	UNIT	NAMEu32	285	xxx	xxx LOCK	UNIT	NAMEu40	150	0	9000	UNIT	NAMEu44	150	0	9000	UNIT	NAMEu51	55	0	9000
UNIT	NAMEu33	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu33	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu41	150	0	9000	UNIT	NAMEu45	150	0	9000	UNIT	NAMEu52	55	0	9000
UNIT	NAMEu34	201	xxx	LOCK	UNIT	NAMEu34	201	xxx	LOCK	UNIT	NAMEu42	150	0	9000	UNIT	NAMEu46	150	0	9000	UNIT	NAMEu53	55	0	9000
UNIT	NAMEu35	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu35	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu43	150	0	9000	UNIT	NAMEu47	150	0	9000	UNIT	NAMEu54	55	0	9000
UNIT	NAMEu36	285	xxx	xxx LOCK	UNIT	NAMEu36	285	xxx	xxx LOCK	UNIT	NAMEu44	150	0	9000	UNIT	NAMEu48	150	0	9000	UNIT	NAMEu55	55	0	9000
UNIT	NAMEu37	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu37	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu45	150	0	9000	UNIT	NAMEu49	150	0	9000	UNIT	NAMEu56	55	0	9000
UNIT	NAMEu38	201	xxx	LOCK	UNIT	NAMEu38	201	xxx	LOCK	UNIT	NAMEu46	150	0	9000	UNIT	NAMEu50	150	0	9000	UNIT	NAMEu57	55	0	9000
UNIT	NAMEu39	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu39	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu47	150	0	9000	UNIT	NAMEu51	150	0	9000	UNIT	NAMEu58	55	0	9000
UNIT	NAMEu40	285	xxx	xxx LOCK	UNIT	NAMEu40	285	xxx	xxx LOCK	UNIT	NAMEu48	150	0	9000	UNIT	NAMEu52	150	0	9000	UNIT	NAMEu59	55	0	9000
UNIT	NAMEu41	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu41	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu49	150	0	9000	UNIT	NAMEu53	150	0	9000	UNIT	NAMEu60	55	0	9000
UNIT	NAMEu42	201	xxx	LOCK	UNIT	NAMEu42	201	xxx	LOCK	UNIT	NAMEu50	150	0	9000	UNIT	NAMEu54	150	0	9000	UNIT	NAMEu61	55	0	9000
UNIT	NAMEu43	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu43	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu51	150	0	9000	UNIT	NAMEu55	150	0	9000	UNIT	NAMEu62	55	0	9000
UNIT	NAMEu44	285	xxx	xxx LOCK	UNIT	NAMEu44	285	xxx	xxx LOCK	UNIT	NAMEu52	150	0	9000	UNIT	NAMEu56	150	0	9000	UNIT	NAMEu63	55	0	9000
UNIT	NAMEu45	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu45	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu53	150	0	9000	UNIT	NAMEu57	150	0	9000	UNIT	NAMEu64	55	0	9000
UNIT	NAMEu46	201	xxx	LOCK	UNIT	NAMEu46	201	xxx	LOCK	UNIT	NAMEu54	150	0	9000	UNIT	NAMEu58	150	0	9000	UNIT	NAMEu65	55	0	9000
UNIT	NAMEu47	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu47	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu55	150	0	9000	UNIT	NAMEu59	150	0	9000	UNIT	NAMEu66	55	0	9000
UNIT	NAMEu48	285	xxx	xxx LOCK	UNIT	NAMEu48	285	xxx	xxx LOCK	UNIT	NAMEu56	150	0	9000	UNIT	NAMEu60	150	0	9000	UNIT	NAMEu67	55	0	9000
UNIT	NAMEu49	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu49	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu57	150	0	9000	UNIT	NAMEu61	150	0	9000	UNIT	NAMEu68	55	0	9000
UNIT	NAMEu50	201	xxx	LOCK	UNIT	NAMEu50	201	xxx	LOCK	UNIT	NAMEu58	150	0	9000	UNIT	NAMEu62	150	0	9000	UNIT	NAMEu69	55	0	9000
UNIT	NAMEu51	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu51	236	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu59	150	0	9000	UNIT	NAMEu63	150	0	9000	UNIT	NAMEu70	55	0	9000
UNIT	NAMEu52	285	xxx	xxx LOCK	UNIT	NAMEu52	285	xxx	xxx LOCK	UNIT	NAMEu60	150	0	9000	UNIT	NAMEu64	150	0	9000	UNIT	NAMEu71	55	0	9000
UNIT	NAMEu53	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu53	525	xxx	MIRROR SPRING ATTACHMENT	UNIT	NAMEu61	150	0	9000	UNIT									

FIG. 81

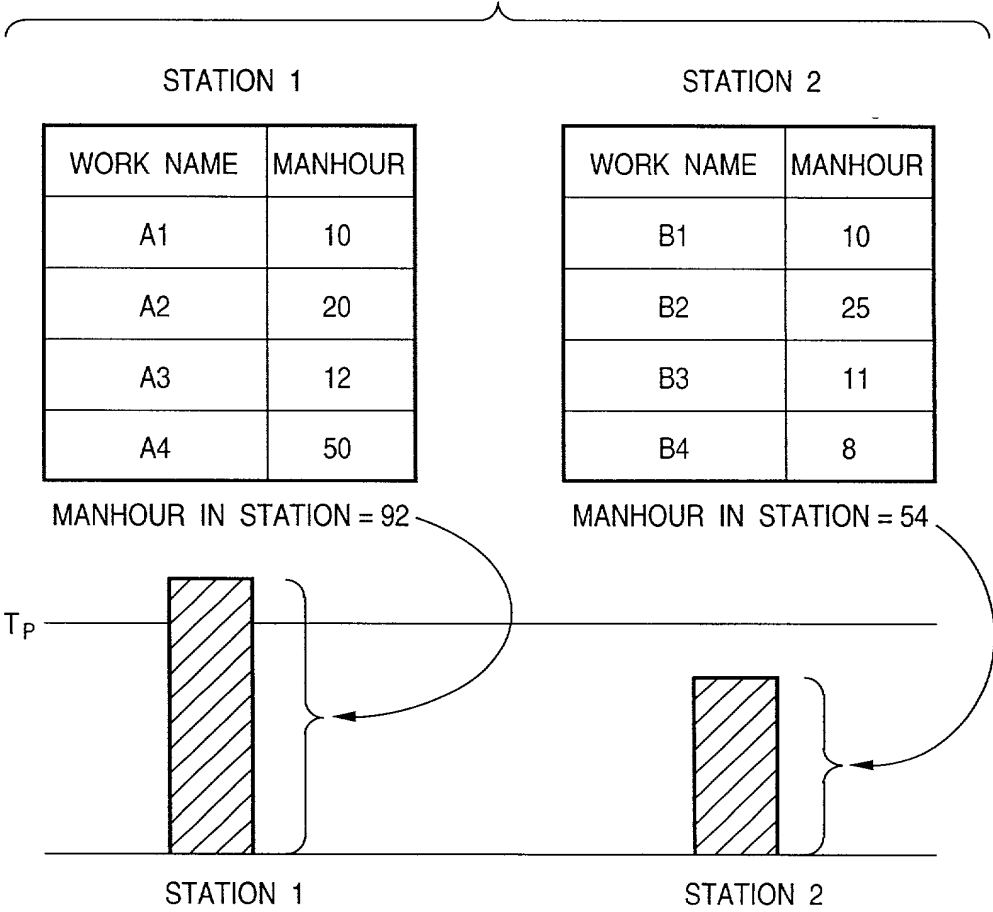


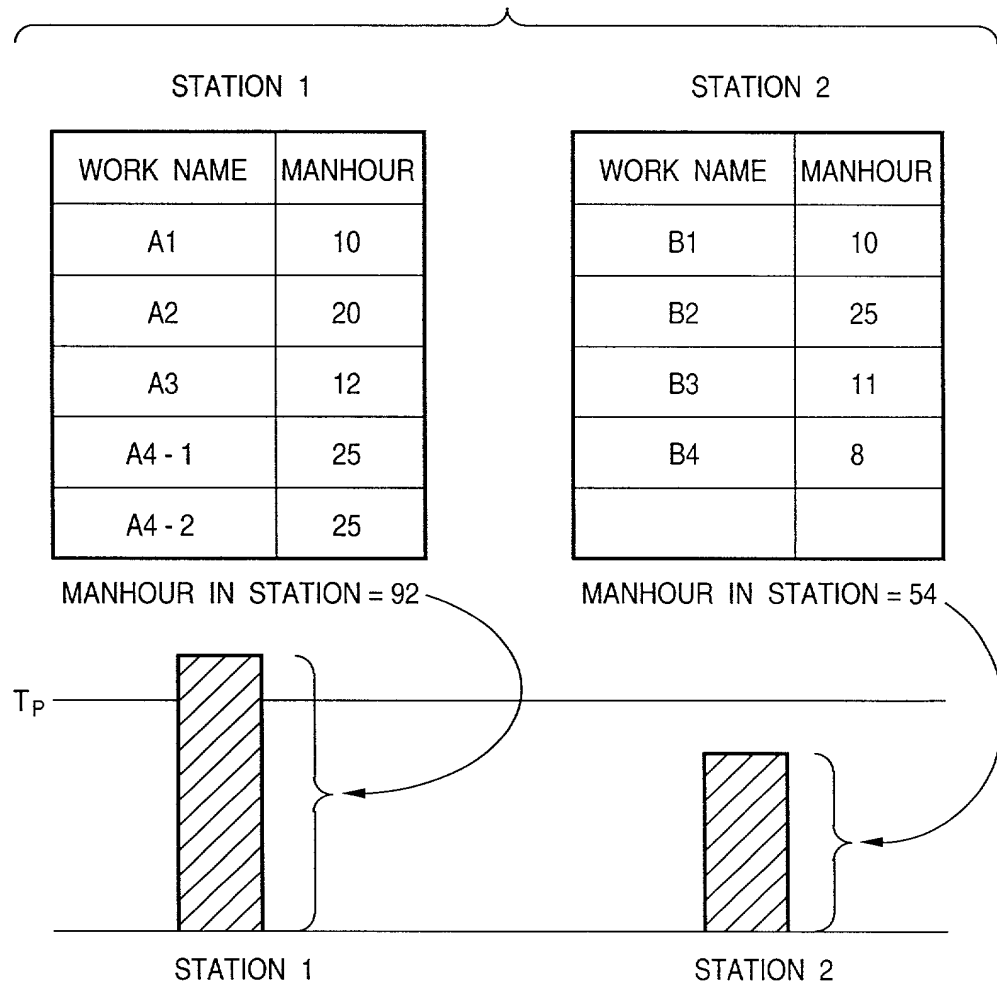
FIG. 82

FIG. 83

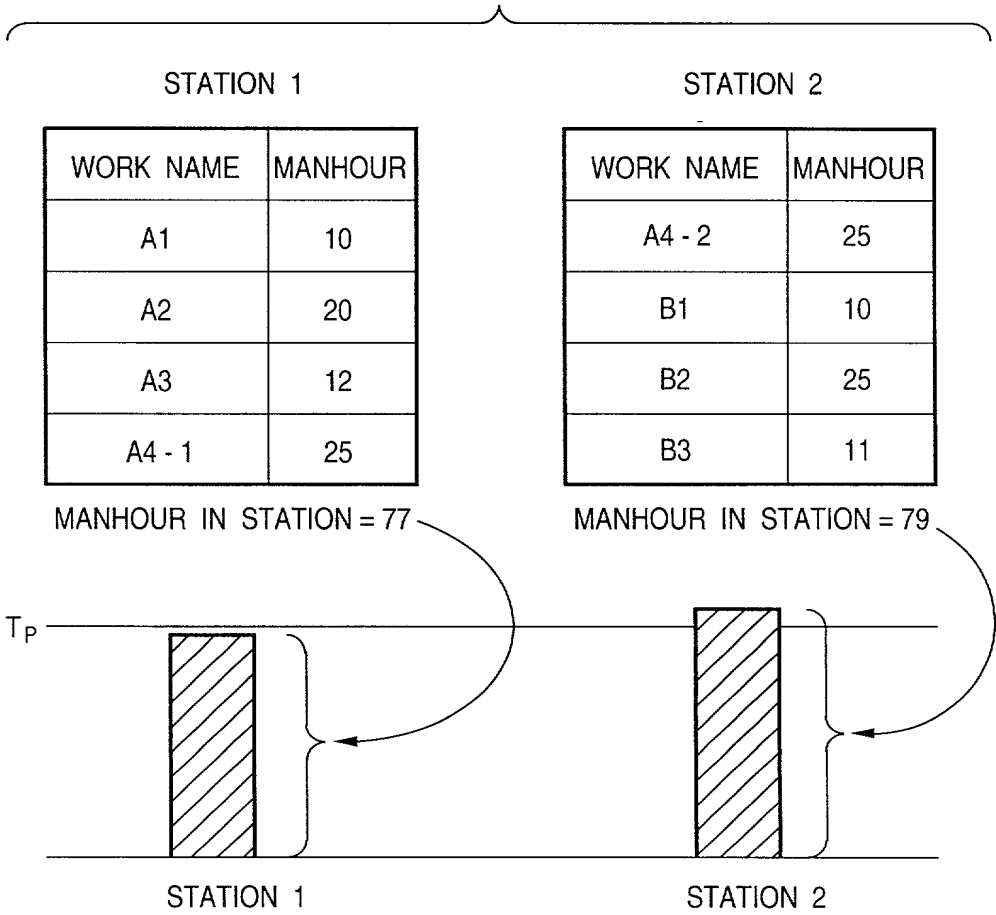


FIG. 84

PARALLEL OPERATION / INTEGRATION OF STATIONS ×

TARGET STATION : 1

8401 THE NUMBER OF STATIONS 8402

FIG. 85

FILE(E) EDIT(E) VIEW(D) TOOL(I)

OPERATOR 1

St1

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL
START	0	0	No
UNIT WORK NAME 1	34	10	No 01
UNIT WORK NAME 2	255	46	No 02
UNIT WORK NAME 6	92	26	No 06
UNIT WORK NAME 7	52	0	No 07
UNIT WORK NAME 8	52	0	No 06
UNIT WORK NAME 9	0	36	No 09

TOTAL 585 (RU)

OPERATOR 2

St2

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL
UNIT WORK NAME 3	156	0	No 03
UNIT WORK NAME 4	34	0	No 04
UNIT WORK NAME 5	138	23	No 06
UNIT WORK NAME 10	71	48	No 10
UNIT WORK NAME 11	138	30	No 11
UNIT WORK NAME 12	97	20	No 12
UNIT WORK NAME 13	88	0	No 14
UNIT WORK NAME 14	46	18	No 15
UNIT WORK NAME 15	546	15	No 16
UNIT WORK NAME 16	58	20	No 17

TOTAL 1548 (RU) xxxxxx

OPERATOR 3

St3

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL
UNIT WORK NAME 13	30	40	No 13
UNIT WORK NAME 16	303	131	No 18

TOTAL 572 (RU)

OPERATOR 4

St4

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL
UNIT WORK NAME 19	84	26	No 19
UNIT WORK NAME 20	120	20	No 20
UNIT WORK NAME 21	310	66	No 21

TOTAL 623 (RU)

OPERATOR 5

St5

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL
UNIT WORK NAME 22	146	71	No 22
UNIT WORK NAME 23	106	26	No 23
UNIT WORK NAME 24	61	0	No 24
UNIT WORK NAME 25	51	10	No 25
END	0	0	No X

TOTAL 486 (RU)

PF 83.6%

PF 96.7%

PF 95.2%

PF 73.6%

PARALLEL STATIONS

900

720

540

360

180

0

1

2

3

4

5

tp

tp*1.05

tp*0.85

t

G STANDARD NO.

WORK NAME

WF

MA- CHINE

PROV- SIONAL MANHOUR

REMARKS

COMPOSITION EFFICIENCY

116

%

NET COMPOSITION EFFICIENCY

%

COMPOSITION MODE: PRIORITY ORDER SCHEME

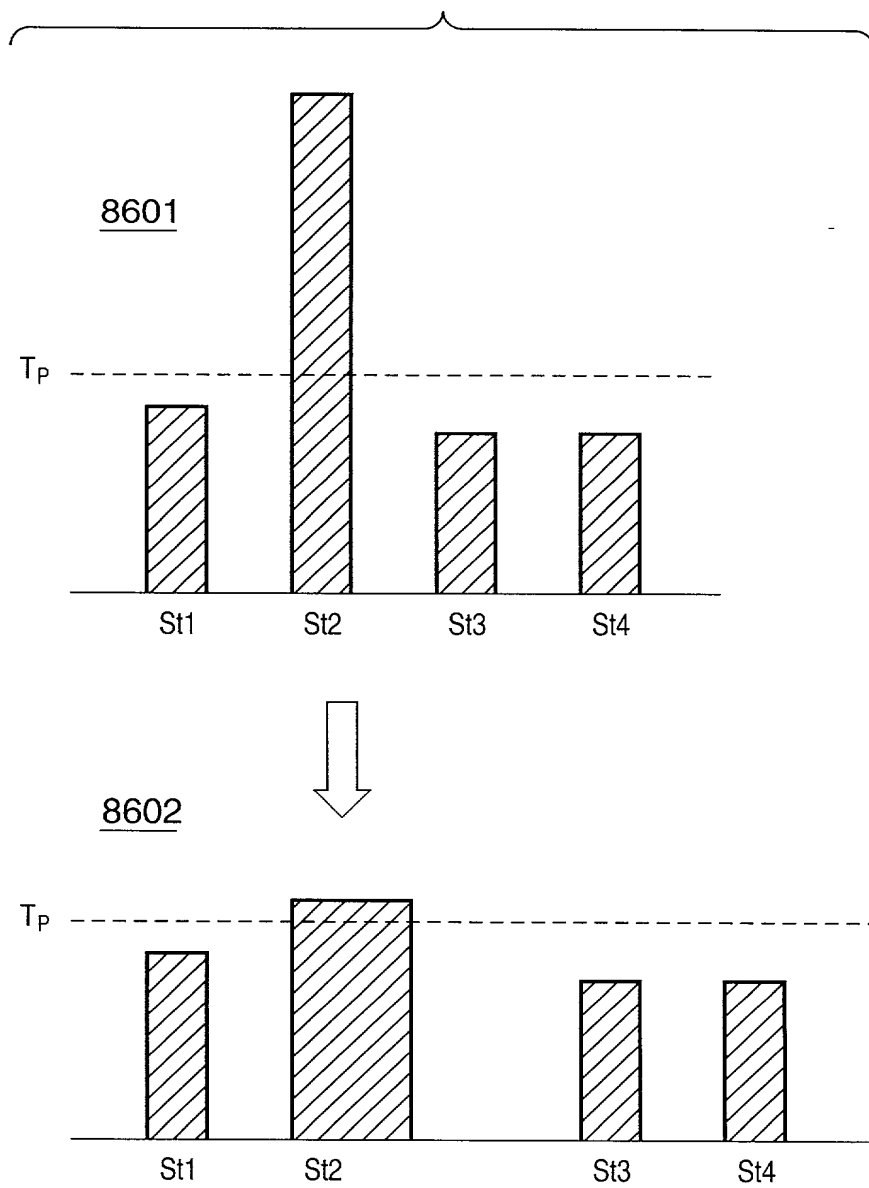
FIG. 86

FIG. 87

USER REGISTRATION

NAME CODE :

12345

8701

NAME :

田中

一郎

8702

POSITION :

kumitate

▼

8703

PASSWORD :

12345

8704

AUTHORITY :

8705

OK

CANCEL

FIG. 88

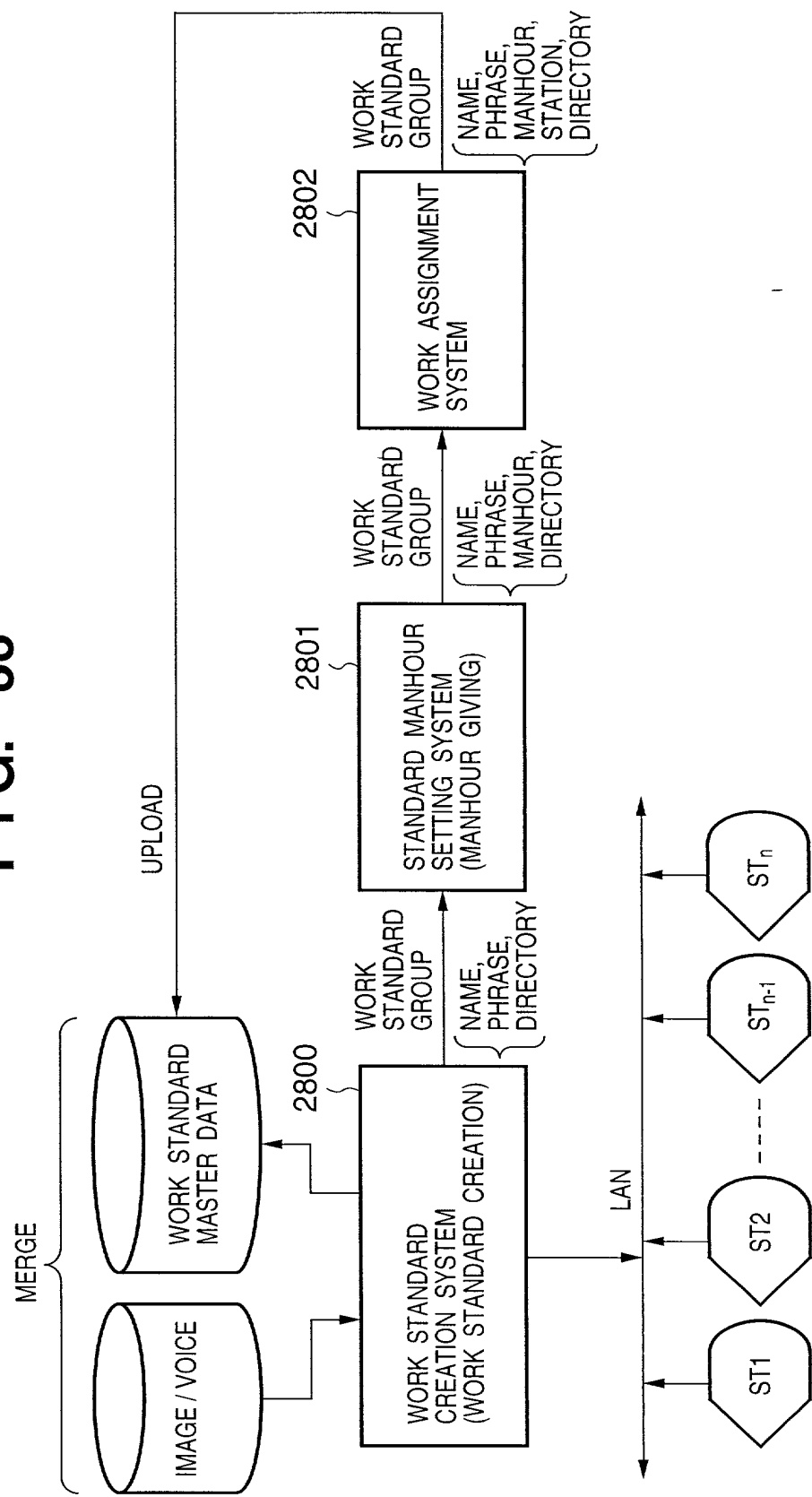


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

FIG. 90

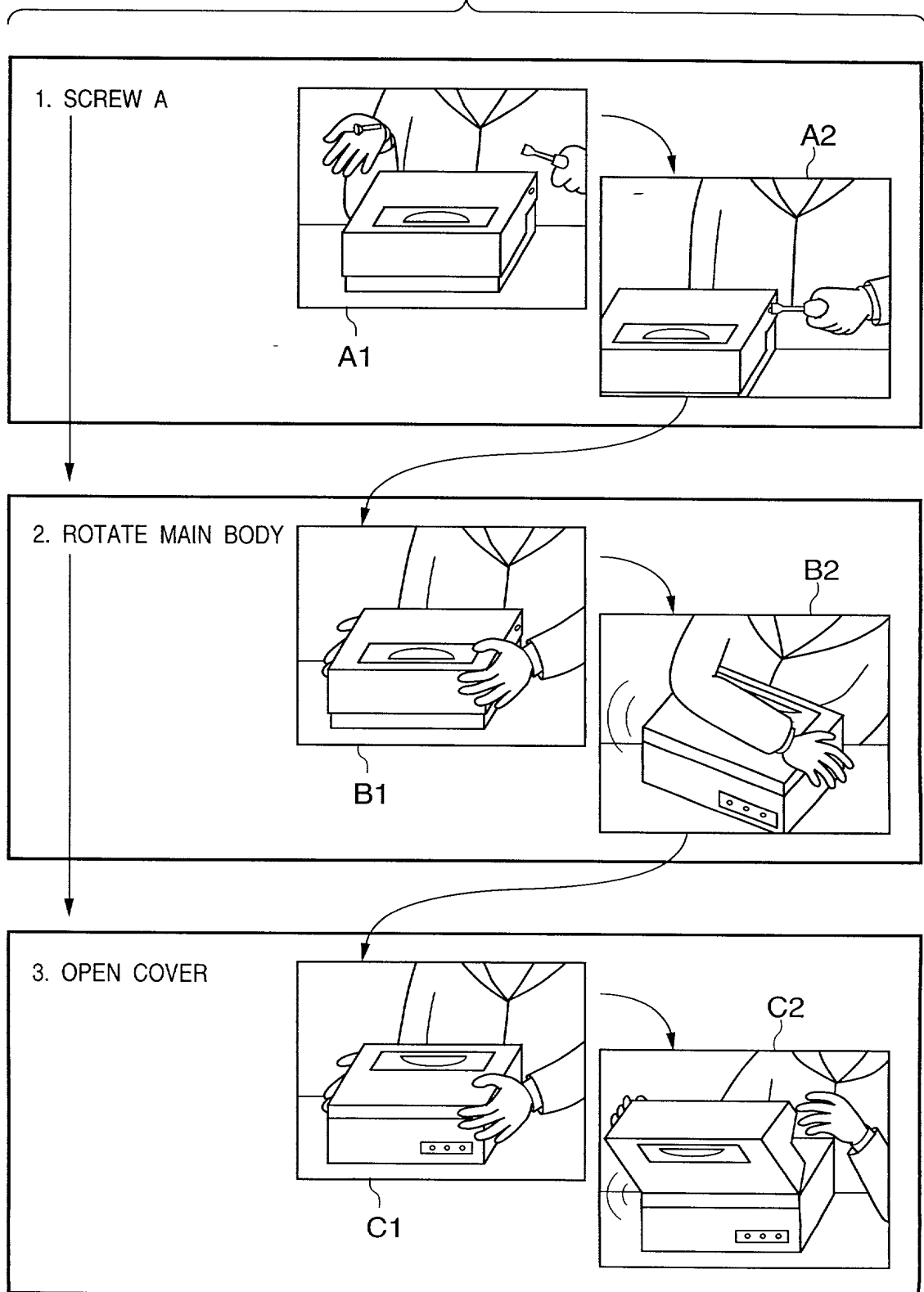


FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

FIG. 92

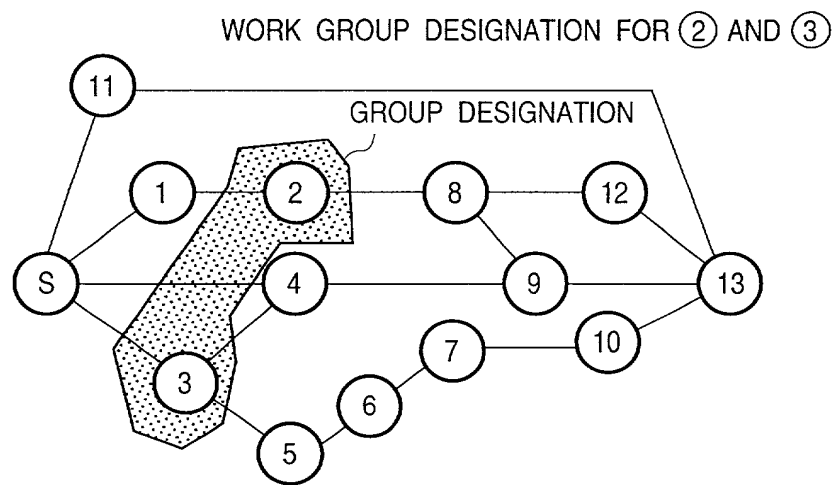


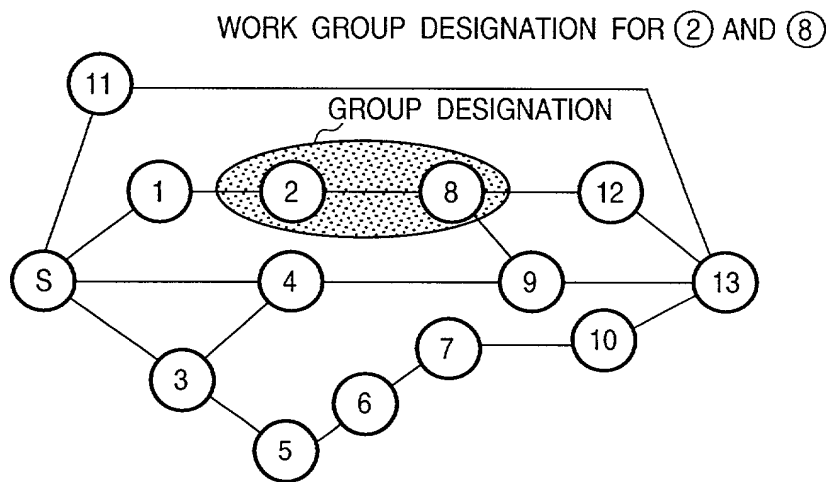
FIG. 93

FIG. 94

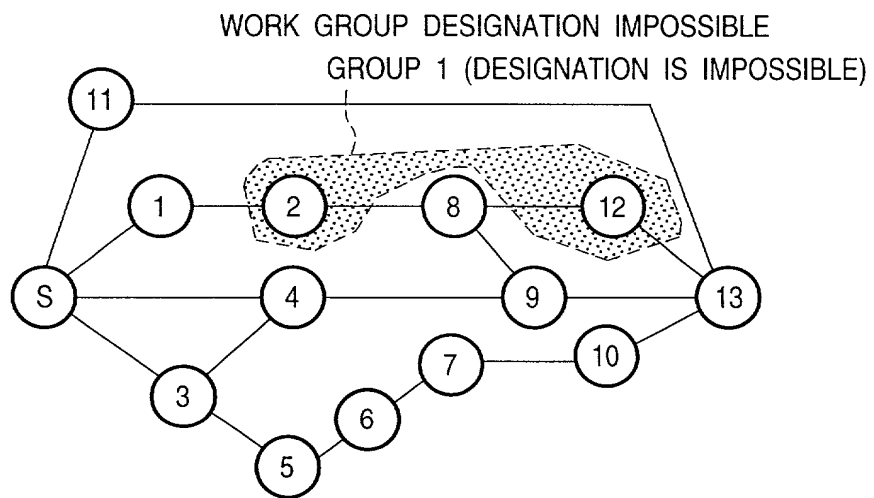
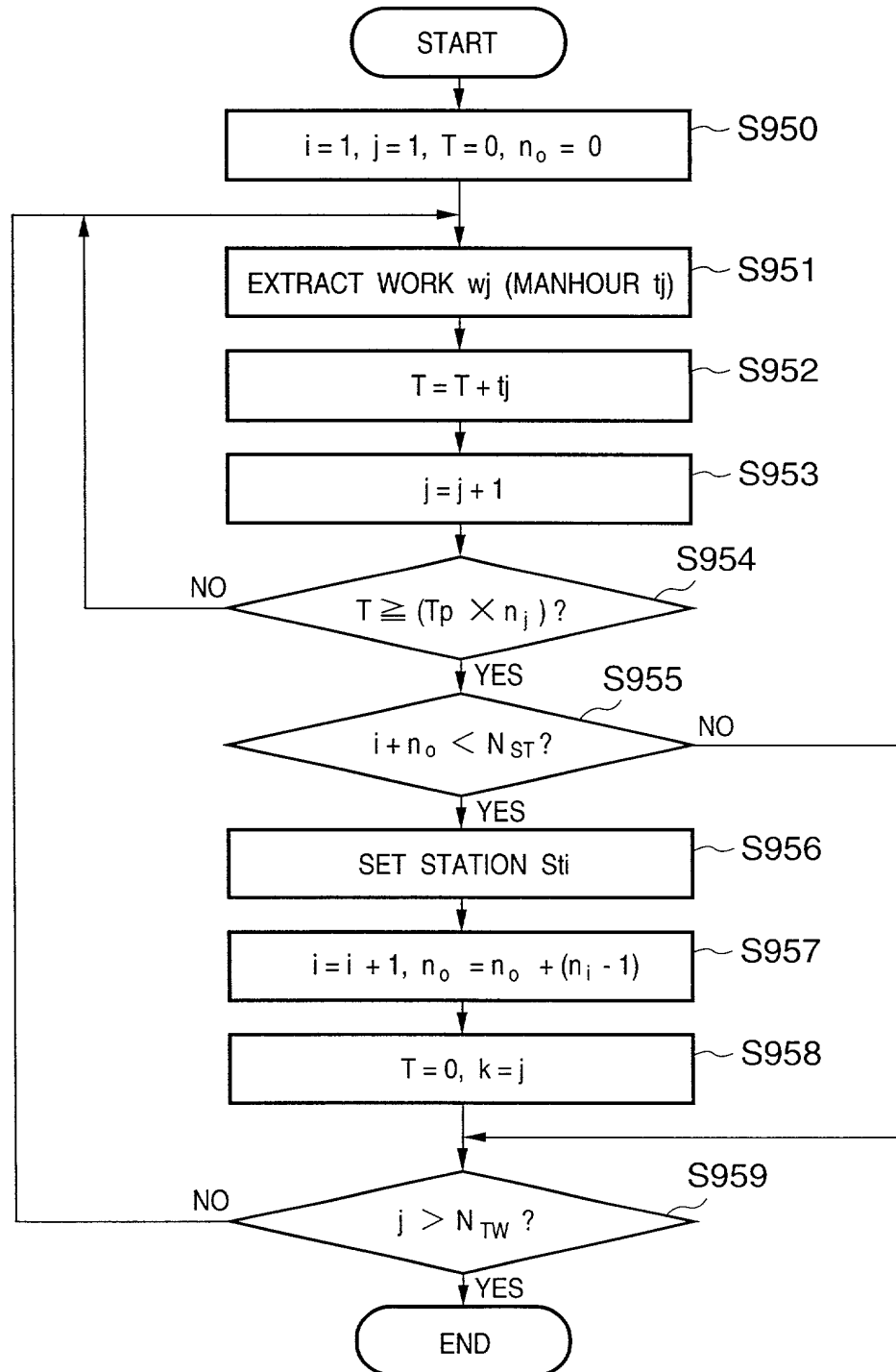
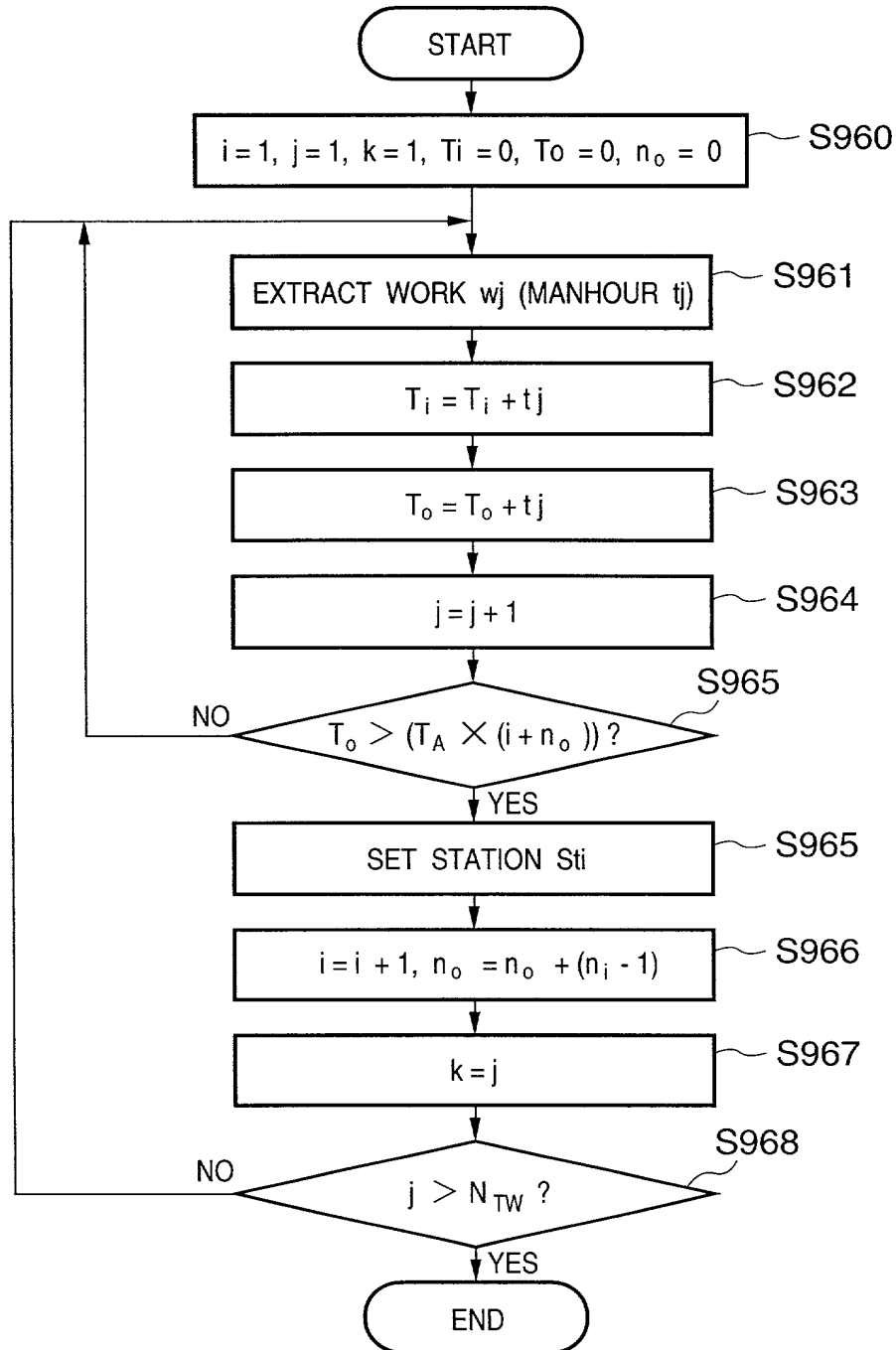


FIG. 95

N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS
 T_i : i STATION MANHOUR
 T_A : STATION MANHOUR AVERAGE VALUE
 $T_A = WF / N_{ST}$
 T_o : TOTAL ACCUMULATED MANHOUR
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 97

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

S11

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	MAN- UAL
START	0	0	No	
UNIT WORK NAME 1	34	10	No 01	
UNIT WORK NAME 2	255	46	No 02	
UNIT WORK NAME 6	92	26	No 06	
UNIT WORK NAME 7	52	0	No 07	
UNIT WORK NAME 8	52	0	No 06	
UNIT WORK NAME 9	0	36	No 09	

TOTAL 585 (RU)

PF 83.6%

PARALLEL STATIONS

OPERATOR 2

S12

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	MAN- UAL
UNIT WORK NAME 3	156	0	No 03	
UNIT WORK NAME 4	34	0	No 04	
UNIT WORK NAME 5	138	23	No 06	
UNIT WORK NAME 10	71	48	No 10	
UNIT WORK NAME 11	138	30	No 11	
UNIT WORK NAME 12	97	20	No 12	
UNIT WORK NAME 13	88	0	No 14	
UNIT WORK NAME 14	46	18	No 15	
UNIT WORK NAME 15	546	15	No 16	
UNIT WORK NAME 17	58	20	No 17	

TOTAL 1548 (RU) xxxxxx

PF 117.3%

PARALLEL STATIONS

OPERATOR 3

S13

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	MAN- UAL
UNIT WORK NAME 13	30	40	No 13	
UNIT WORK NAME 16	303	131	No 18	

TOTAL 572 (RU)

PF 96.7%

PARALLEL STATIONS

OPERATOR 4

S14

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	MAN- UAL
UNIT WORK NAME 19	84	26	No 19	
UNIT WORK NAME 20	120	20	No 20	
UNIT WORK NAME 21	310	66	No 21	

TOTAL 6238 (RU)

PF 95.2%

PARALLEL STATIONS

OPERATOR 5

S15

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	MAN- UAL
UNIT WORK NAME 22	146	71	No 22	
UNIT WORK NAME 23	106	26	No 23	
UNIT WORK NAME 24	61	0	No 24	
UNIT WORK NAME 25	51	10	No 25	
END	0	0	No X	

TOTAL 486 (RU)

PF 73.6%

PARALLEL STATIONS

OPERATOR 6

S16

WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	MAN- UAL
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TOTAL 0 (RU)

PF 0.0%

PARALLEL STATIONS

G STANDARD NO.

WORK NAME

MA- CHINE MANHOUR

PROVISIONAL REMARKS

COMPOSITION EFFICIENCY

96.43

%

NET COMPOSITION EFFICIENCY

%

COMPOSITION MODE: PRIORITY ORDER SCHEME